STEEL CITY®

User Manual

Read and understand this manual before using machine.

14" DELUXE GRANITE BAND SAW

Model Number 50130

C US

STEEL CITY TOOL WORKS
VER. 12.08

Manual Part No. OR73672

THANK YOU for purchasing your new Steel City Bandsaw. This bandsaw has been designed, tested, and inspected with you, the customer, in mind. When properly assembled, used and maintained, your bandsaw will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This bandsaw is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your bandsaw or Steel City Tool Works, please visit our web site at **www.steelcitytoolworks.com** .

TABLE OF CONTENTS

INTRODUCTION

SECTION 1 Warranty 4

SECTION 2 Product Specifications 8

SECTION 3 Accessories and Attachments 8

SECTION 4 Definition of Terms 8

SECTION 5 Feature Identification 9

SECTION 6 General Safety 10

SECTION 7 Product Safety 12

SECTION 8 Electrical Requirements 13

SECTION 9 Unpacking & Inventory 15

SECTION 10 Assembly 19

SECTION 11 Adjustments 25

SECTION 12 Operations 30

SECTION 13 Maintenance 32

SECTION 14 Troubleshooting 33

SECTION 15 Parts List 34

INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

WARRANTY

STEEL CITY TOOL WORKS
5 YEAR LIMITED WARRANTY

Steel City Tool Works, LLC ("SCTW") warrants all "STEEL CITY TOOL WORKS" machinery to be free of defects in workmanship and materials for a period of 5 years from the date of the original retail purchase by the original owner. (Granite components are warranted for 10 years. See the Granite warranty statement supplied with those products.) SCTW will repair or replace, at its expense and at its option, any SCTW machine, machine part, or machine accessory which in normal use has proven to be defective, provided that the customer returns the product, shipping prepaid, to an authorized service center with proof of purchase and provides SCTW with a reasonable opportunity to verify the alleged defect by inspection. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, or lack of maintenance, or to repairs or alterations made or specifically authorized by anyone other than SCTW. Normal wear components are also excluded under this coverage. Every effort has been made to ensure that all SCTW machinery meets the highest quality and durability standards. We reserve the right to change specifications at any time due to our commitment to continuous improvement of the quality of our products.

EXCEPT AS SET FORTH ABOVE, SCTW MAKES NO EXPRESS OR IMPLIED REPRESENTATIONS OR WARRANTIES WITH RESPECT TO ITS MACHINERY, OR ITS CONDITION, MERCHANTABILITY, OR FITNESS FOR ANY PARTICULAR PURPOSE OR USE. SCTW FURNISHES THE ABOVE WARRANTIES IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHICH ARE HEREBY SPECIFICALLY DISCLAIMED.

SCTW SHALL NOT BE LIABLE FOR ANY (A) SPECIAL, INDIRECT, INCIDENTAL, PUNITIVE OR CONSEQUENTIAL DAMAGES, INCLUDING WITHOUT LIMITATION LOSS OF PROFITS, ARISING FROM OR RELATED TO THIS WARRANTY, THE BREACH OF ANY AGREEMENT OR WARRANTY, OR THE OPERATION OR USE OF ITS MACHINERY, INCLUDING WITHOUT LIMITATION DAMAGES ARISING FROM DAMAGE TO FIXTURES, TOOLS, EQUIPMENT, PARTS OR MATERIALS, DIRECT OR INDIRECT LOSS CAUSED BY ANY OTHER PARTY, LOSS OF REVENUE OR PROFITS, FINANCING OR INTEREST CHARGES, AND CLAIMS BY ANY THIRD PERSON, WHETHER OR NOT NOTICE OF SUCH POSSIBLE DAMAGES HAS BEEN GIVEN TO SCTW; (B) DAMAGES OF ANY KIND FOR ANY DELAY BY OR FAILURE OF SCTW TO PERFORM ITS OBLIGATIONS UNDER THIS AGREEMENT; OR (C) CLAIMS MADE A SUBJECT OF A LEGAL PROCEEDING AGAINST SCTW MORE THAN ONE (1) YEAR AFTER SUCH CAUSE OF ACTION FIRST AROSE.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the laws of the Commonwealth of Pennsylvania, without regard to conflicts of laws provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW, or any claim related to the performance of any agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

WARRANTY CARD

Name _____
Street _____
Apt. No. _____
City _____ State _____ Zip _____
Phone Number _____
E-Mail _____

Product Description: _____
Model No.: _____
Serial No. _____

The following information is given on a voluntary basis and is strictly confidential.

1. Where did you purchase your STEEL CITY machine?
   Store: _____
   City: _____

2. How did you first learn of Steel City Tool Works?
   ___ Advertisement ___ Mail Order Catalog
   ___ Web Site ___ Friend
   ___ Local Store Other_____

3. Which of the following magazines do you subscribe to?
   ___ American Woodworker ___ American How-To
   ___ Cabinetmaker ___ Family Handyman
   ___ Fine Homebuilding ___ Fine Woodworking
   ___ Journal of Light Construction ___ Old House Journal
   ___ Popular Mechanics ___ Popular Science
   ___ Popular Woodworking ___ Today's Homeowner
   ___ WOOD ___ Woodcraft
   ___ WOODEN Boat ___ Woodshop News
   ___ Woodsmith ___ Woodwork
   ___ Woodworker ___ Woodworker's Journal
   ___ Workbench Other_____

4. Which of the following woodworking / remodeling shows do you watch?
   ___ Backyard America ___ The American Woodworker
   ___ Home Time ___ The New Yankee Workshop
   ___ This Old House ___ Woodwright's Shop
   Other_____

5. What is your annual household income?
   ___ $20,000 to $29,999 ___ $30,000 to $39,999
   ___ $40,000 to $49,999 ___ $50,000 to $59,999
   ___ $60,000 to $69,999 ___ 70,000 to $79,999
   ___ $80,000 to $89,999 ___ $90,000 +

6. What is your age group?
   ___ 20 to 29 years ___ 30 to 39 years
   ___ 40 to 49 years ___ 50 to 59 years
   ___ 60 to 69 years ___ 70 + years

7. How long have you been a woodworker?
   ___ 0 to 2 years ___ 2 to 8 years
   ___ 8 to 20 years ___ over 20 years

8. How would you rank your woodworking skills?
   ___ Simple ___ Intermediate
   ___ Advance ___ Master Craftsman

9. How many Steel City machines do you own? _____

10. What stationary woodworking tools do you own?
    Check all that apply.
    ___ Air Compressor ___ Band Saw
    ___ Drill Press ___ Drum Sander
    ___ Dust Collection ___ Horizontal Boring Machine
    ___ Jointer ___ Lathe
    ___ Mortiser ___ Panel Saw
    ___ Planer ___ Power Feeder
    ___ Radial Arm Saw ___ Shaper
    ___ Spindle Sander ___ Table Saw
    ___ Vacuum Veneer Press ___ Wide Belt Sander
    Other_____

11. Which benchtop tools do you own? *Check all that apply.*
    ___ Belt Sander ___ Belt / Disc Sander
    ___ Drill Press ___ Band Saw
    ___ Grinder ___ Mini Jointer
    ___ Mini Lathe ___ Scroll Saw
    ___ Spindle / Belt Sander Other_____

12. Which portable / hand held power tools do you own?
    Check all that apply.
    ___ Belt Sander ___ Biscuit Jointer
    ___ Dust Collector ___ Circular Saw
    ___ Detail Sander ___ Drill / Driver
    ___ Miter Saw ___ Orbital Sander
    ___ Palm Sander ___ Portable Thickness Planer
    ___ Saber Saw ___ Reciprocating Saw
    ___ Router Other_____

13. What machines / accessories would you like to see added to the STEEL CITY line?
    _____
    _____

14. What new accessories would you like to see added?
    _____
    _____

15. Do you think your purchase represents good value?
    ___Yes ___ No

16. Would you recommend STEEL CITY products to a friend?
    ___ Yes ___ No

17. Comments:
    _____
    _____
    _____
    _____
    _____

CUT HERE

FOLD ON DOTTED LINE

PLACE
STAMP
HERE

Steel City Tool Works
201 Ann Street
Suite 200
Pittsburgh, PA 15139

FOLD ON DOTTED LINE

WARRANTY

STEEL CITY TOOL WORKS
EXCLUSIVE SUPPLIER OF WOODWORKING MACHINERY
WITH GRANITE WORK SURFACE COMPONENTS

10 YEAR LIMITED WARRANTY ON GRANITE COMPONENTS

Steel City Tool Works takes great pride in the innovative development of solid GRANITE work surface components for woodworking machinery. Its consistent flatness, stability, and ease of care compared to other more common work surfaces, are major advantages to woodworkers.

GRANITE is a natural resource, quarried and processed for use in our machines. Because of its natural state, you will find some inconsistencies in the appearance of the material. This is common and should be expected. It makes each machine we produce unique.

Because it is the most consistent throughout the slab, we use only the black variety of GRANITE. Our goal is to provide you with the strongest, most stable work surface available. GRANITE is also easy to maintain with an annual application of a granite sealer, available in many specialty, home improvement or retail outlets.

To support our belief that you will find Steel City's GRANITE as strong, stable and reliable as we have, we offer the following 10 YEAR LIMITED WARRANTY on all GRANITE components. This warranty is offered in conjunction with our standard 5 YEAR LIMITED WARRANTY on all other machine components and parts.

STEEL CITY 10 YEAR WARRANTY ON GRANITE COMPONENTS

Steel City Tool Works, LLC (SCTW) warrants all granite components of your "Steel City Tool Works" machine to be free from defects of workmanship and materials for a full ten (10) years from the date of the original retail purchase by the original owner. SCTW will repair or replace, at its option and expense, any Steel City granite component which, in normal use, has proven to be defective, provided that the customer returns the component, shipping prepaid, to an authorized service facility with proof of purchase and provides SCTW with a reasonable opportunity to inspect and verify the alleged defect. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, or to repairs or alterations made or specifically authorized by any party other than SCTW. Granite components which are cracked, broken, or chipped significantly enough to interfere with the operation of the machine or the processing of material are covered by this limited warranty.

See the SCTW 5 Year Limited Warranty that provides the other terms and conditions of this 10 year granite warranty .

PRODUCT SPECIFICATIONS

Cutting Capacity(height)	12"
Cutting Capacity(width)	14"
Blade Length (without optional riser block accessory)	105-1/2"
Blade Speed	1500 / 3000 SFPM
Minimum Blade Width	1/8"
Maximum Blade Width	3/4"
Table Size	16" x 16"
Table Tilt	45R, 3L
Table Height from Floor	43"
Wheel Diameter	14"
Dust Port Size	4"

MOTOR

Horsepower	1-1/2HP
Amps	14 / 7A
Volts1	15 / 230V
Phase	single
Hertz	60Hz
RPM	1725

PRODUCT DIMENSIONS

Footprint	16-1/4 " x 18-1/4"
Width	27"
Depth	19"
Height	74"
Net Weight	298 lbs

SHIPPING DIMENSIONS:

BANDSAW

Carton Type	cardboard carton
Width	24"
Depth	51"
Height	17"
Gross Weight	283 lbs.

BASE

Carton Type	cardboard carton
Width	18"
Depth	20-1/2"
Height	26"
Gross Weight	99 lbs.

ACCESSORIES AND ATTACHMENTS

There are a variety of accessories available for your Steel City Product. For more information on any accessories associated with this and other machines, please contact your nearest Steel City distributor, or visit our website at: **www.steelcitytoolworks.com.**

DEFINITION OF TERMS

Blade drift- A problem that may occur when the blade begins to wander off the cutting line.

Crosscutting- Cutting across the grain of the work-piece.

Guide Bearings - Located on either side of the blade, providing stability for blade while in operation

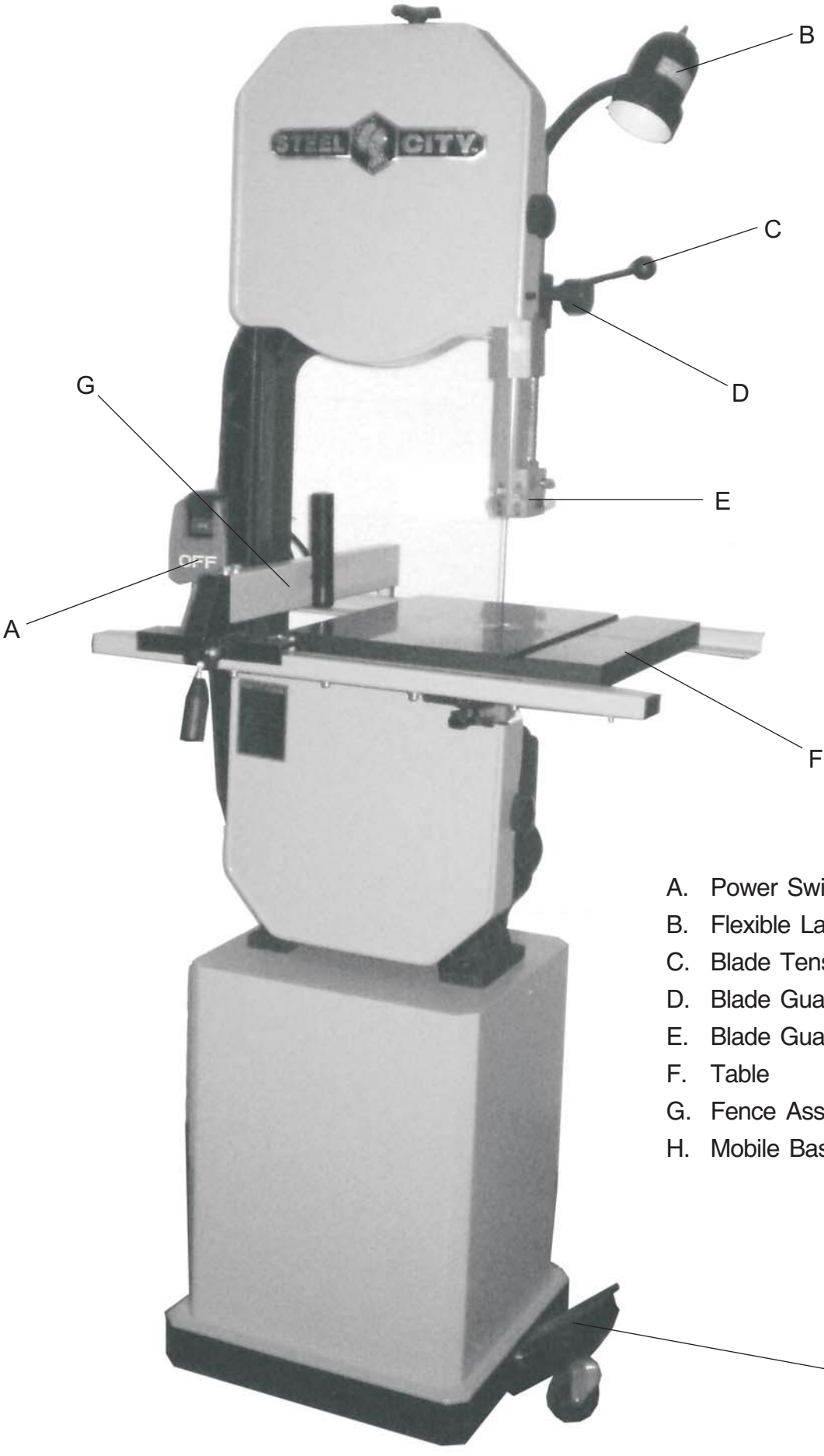
Resaw- The process of slicing stock to reduce its thickness.

Ripping - Cutting lengthwise down the workpiece with the grain of the wood.

Set - Refers to the way in which the saw teeth are ben tor positioned.

Tracking- refers to the position of the saw blade on the wheels while the machine is running.

Thrust Bearing- Located behind the saw blade, pro-viding support to the back of the blade when the saw isin operation.



A. Power Switch
B. Flexible Lamp
C. Blade Tension Cam Handle
D. Blade Guard Adjustment Knob
E. Blade Guard
F. Table
G. Fence Assembly
H. Mobile Base Caster Assembly

GENERAL SAFETY

⚠ WARNING

TO AVOID serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.

⚠

This is the international safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

⚠ DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

⚠ WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

⚠ CAUTION

Indicates a potentially hazardous situation, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

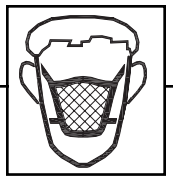
CAUTION

CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

⚠ WARNING



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

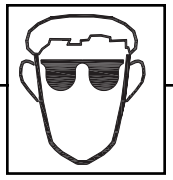
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

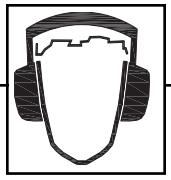
1. To avoid serious injury and damage to the machine, read the entire User Manual before assembly and operation of this machine.

⚠ WARNING



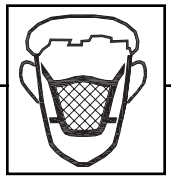
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

⚠ WARNING



3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

⚠ WARNING



4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that has slippery floor surfaces from debris, grease, and wax.

6. **ALWAYS** unplug the machine from the electrical receptacle before making adjustments, changing parts or performing any maintenance.

7. **AVOID ACCIDENTAL STARTING**. Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

⚠ WARNING

8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain or moisture.

⚠ WARNING

9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.

12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.

13. **DO NOT** store anything above or near the machine.

14. **DO NOT** operate any machine or tool if under the influence of drugs, alcohol, or medication.

15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.

16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.

17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.

18. **KEEP** protective guards in place and in working order.

19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.

20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.

21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.

22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.

23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.

24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. **THE USE** of extension cords is not recommended for 230V equipment. It is better to arrange the placement of your equipment and the installed wiring to eliminate the need for an extension cord. If an extension cord is necessary, refer to the chart in the Grounding Instructions section to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin.
27. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
28. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
29. Information regarding the safe and proper operation of this tool is also available from the following sources:

    Power Tool Institute
    1300 Summer Avenue
    Cleveland, OH 44115-2851
    www.powertoolinstitute.org

    National Safety Council
    1121 Spring Lake Drive
    Itasca, IL 60143-3201

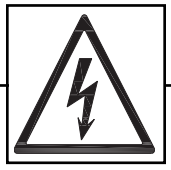
    American National Standards Institute
    25West 43rd. St, 4th Floor
    New York, NY. 10036
    ANSI 01.1 Safety Requirements
    For Woodworking Machines
    WWW.ANSI.ORG

    U.S. Department of Labor Regulations
    OSHA 1910.213 Regulations
    WWW.OSHA.GOV

PRODUCT SAFETY

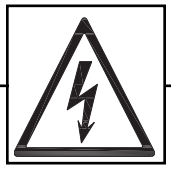
1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

⚠ WARNING



4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.
5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
7. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
8. **ALWAYS** turn the power switch “OFF” before unplugging the bandsaw.

⚠ WARNING



9. **DO NOT** handle the plug or bandsaw with wet hands.

10. **USE** accessories only recommended by Steel City.

11. **DO NOT** pull the bandsaw by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.

12. **DO NOT** unplug the bandsaw by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.

13. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. **DO NOT USE** if the bandsaw is not operating properly, or has been damaged, left outdoors or has been in contact with water.

14. **DO NOT** use the bandsaw as a toy. **DO NOT** use near or around children.

15. **ENSURE** that the machine sits firmly on the floor before using. If the machine wobbles or is unstable, correct the problem by using shims or blocks prior to operation.

16. **MATCH** the blade type and size to the workpiece being cut.

17. **MAKE SURE** that the blade tension is set appropriately for the size of blade being used.

18. **MAKE SURE** that the blade is tracking properly by manually turning the wheels before starting the machine.

19. **ADJUST** all blade guides as specified in the operating instructions.

20. **ADJUST** the upper guide to a point about 1/4" above the workpiece being cut.

21. **DO NOT** cut workpieces that do not have a flat bottom without properly supporting the piece to maintain a stable position.

22. **KEEP** hand and fingers away from blade.

23. **HOLD** workpiece firmly and use a moderate feed speed.

24. **MAKE** "relief" cuts before cutting curves.

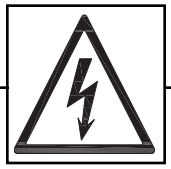
25. **TURN OFF** machine before backing the workpiece out of an incomplete cut.

26. **TURN OFF** the machine before removing scrap pieces.

27. With the machine **TURNED OFF**, clean dust build-up around lower blade guides regularly.

ELECTRICAL REQUIREMENTS

⚠ WARNING



To reduce the risk of electric shock, follow all electrical and safety codes, including the National Electric Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

The switch provided with your saw is a dual voltage capable switch, meaning it is designed to function at either 115 or 230 volts. The switch and saw come prewired for 115 volt operation. If you decide to convert the saw to 230V, you will have to replace the 115 volt plug on the switch with a UL/CSA Listed plug, suitable for 230 volts. The bandsaw with a 230 volt plug should only be connected to an outlet having the same configuration as the plug. No adapter is available or should be used with the 230 volt plug. Once the modification has been made to the plug of the switch, be sure to follow the instructions under CHANGING MOTOR VOLTAGE for changing the motor voltage from 115 volt to 230 volt in the ADJUSTMENTS section of this manual.

GROUNDING INSTRUCTIONS

⚠ WARNING

This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

IMPROPER ELECTRICAL CONNECTION of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

PLUGS/RECEPTACLES

⚠ WARNING

- Electrocution or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

Depending on which model you have, the motor supplied with your machine is either a 115/230 volt, 60 hertz, single phase motor, or a dedicated 230 volt, 60 hertz, single phase motor. Never connect the green or ground wire to a live terminal.

The machine should only be connected to an outlet having the same configuration as the plug.

EXTENSION CORDS

⚠ WARNING

To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

⚠ CAUTION

USE ONLY a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

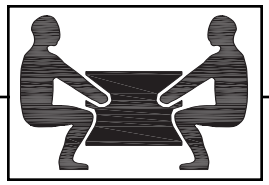
Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)			
115 VOLT OPERATION ONLY			
	25' LONG	**50' LONG**	**100' LONG**
0 to 6 Amps	18 AWG	16 AWG	16 AWG
6 to 10 Amps	18 AWG	16 AWG	14 AWG
10 to 12 Amps	16 AWG	16 AWG	14 AWG
12 to 15 Amps	14 AWG	12 AWG	Not recommended

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)			
230 VOLT OPERATION ONLY			
	25' LONG	**50' LONG**	**100' LONG**
0 to 6 Amps	18 AWG	18 AWG	16 AWG
6 to 10 Amps	18 AWG	18 AWG	14 AWG
10 to 12 Amps	16 AWG	16 AWG	14 AWG
12 to 15 Amps	14 AWG	12 AWG	Not recommended

UNPACKING & INVENTORY

⚠ WARNING



- The machine is heavy, two people are required to unpack and lift.
- Use a safety strap to avoid tip over when lifting machine.

Check shipping carton and machine for damage before unpackaging. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

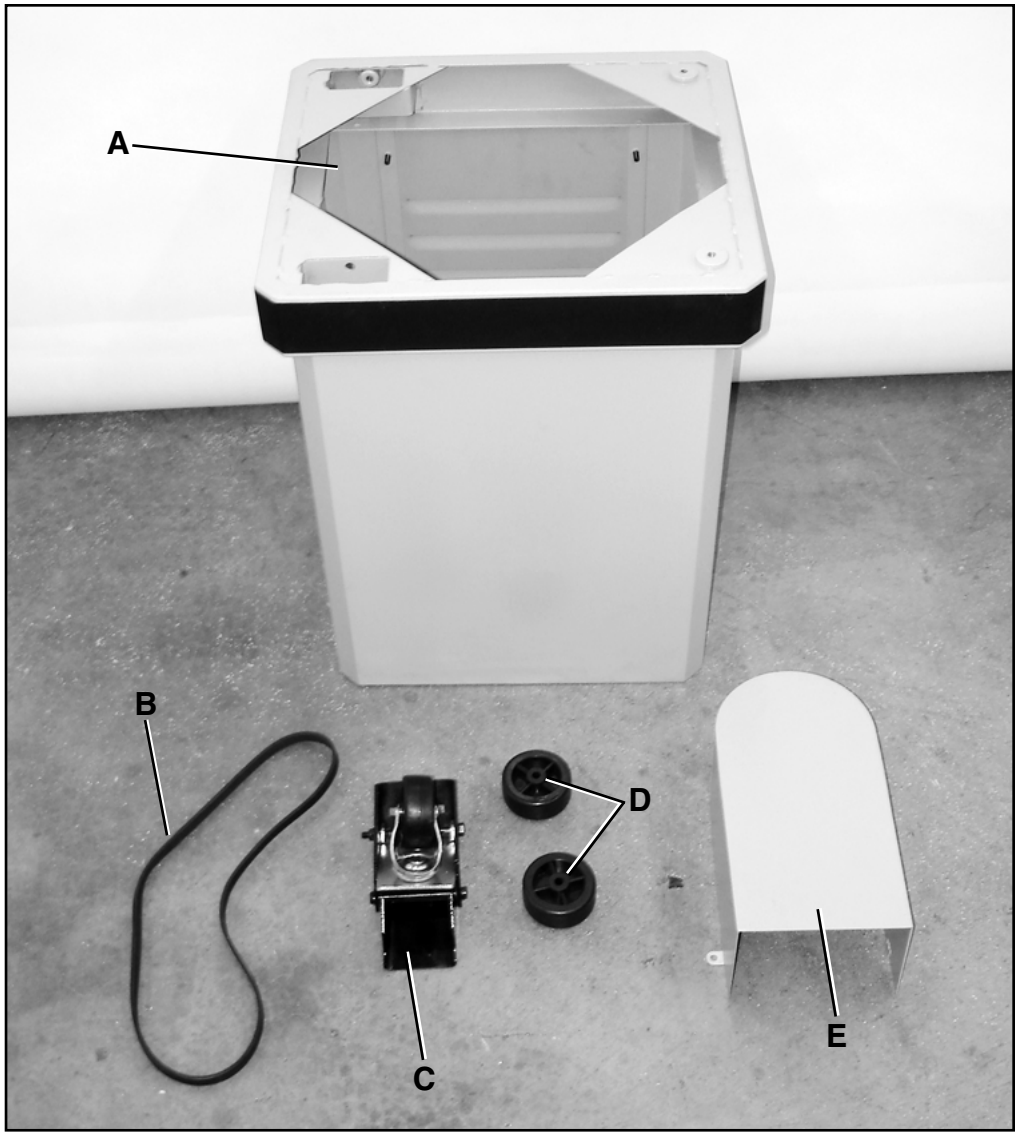
Remove any protective materials and coatings from all of the parts and the bandsaw. After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Compare the items to inventory figures; verify that all items are accounted for before discarding the shipping box.

⚠ WARNING

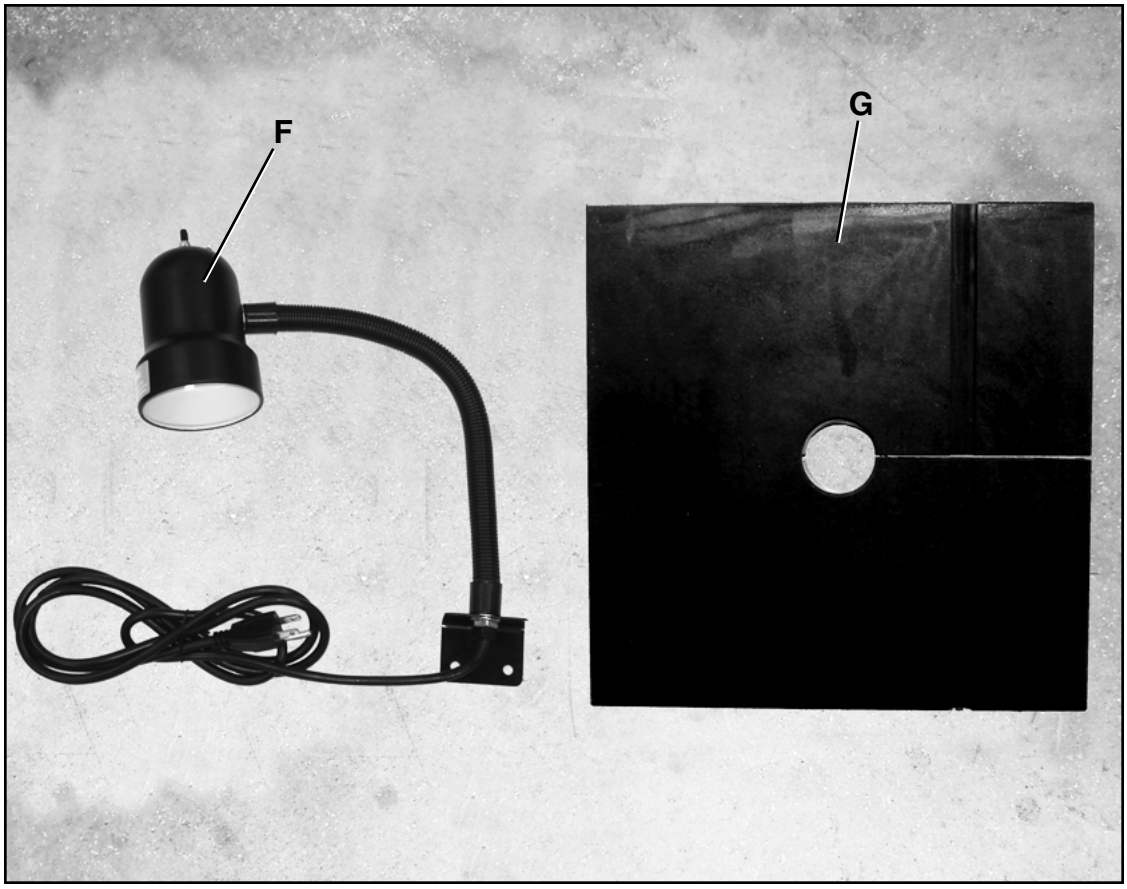
If any parts are missing, do not attempt to plug in the power cord and turn “ON” the machine. The machine should only be turned “ON” after all the parts have been obtained and installed correctly. For missing parts, contact Steel City at 1-877-SC4-TOOL.

A. Base
B. Poly-V Belt
C. Mobile Base Caster Assembly
D. Stationary Wheels (2)
E. Pulley Cover



F. Adjustable Lamp

G. Table



H. Table Lock Knobs

I. 3mm Hex Wrench

J. 4mm Hex Wrench

K. Table Insert

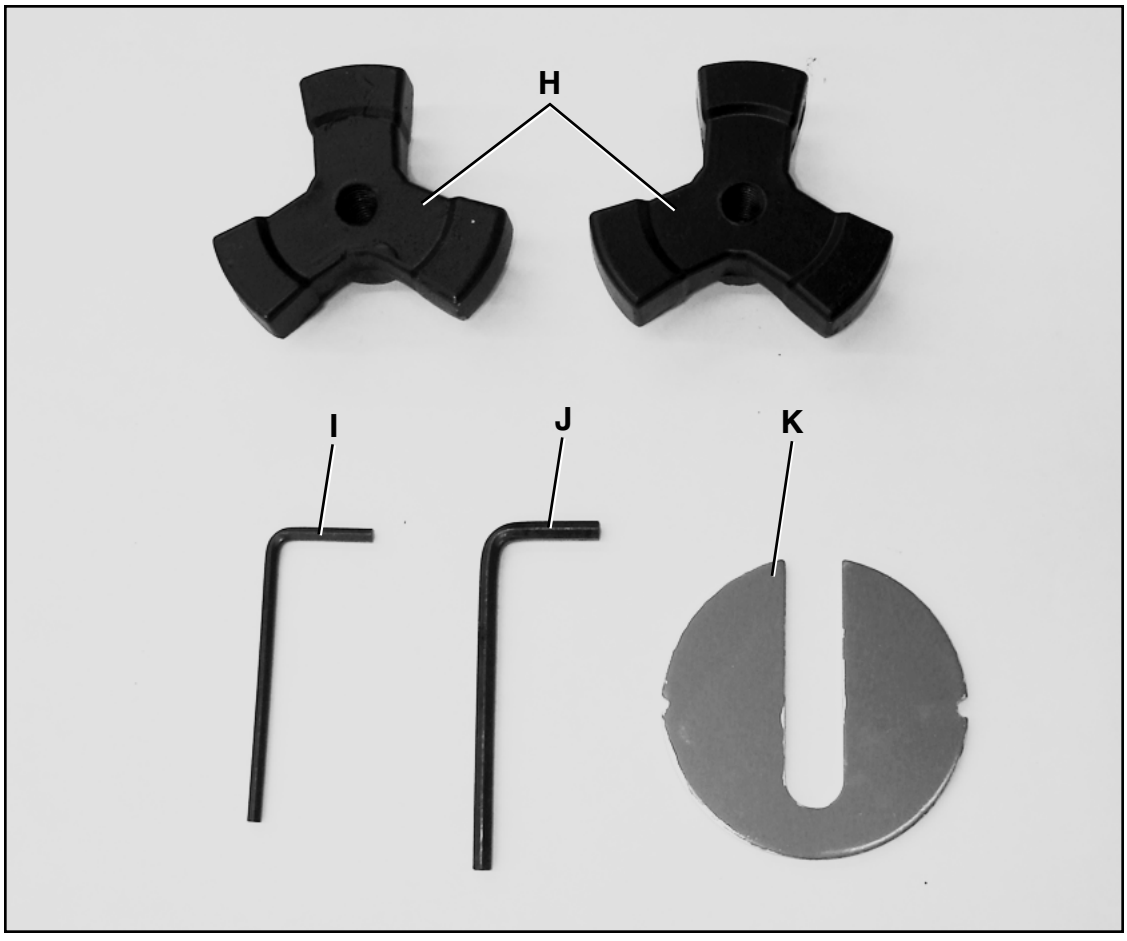
HARDWARE NOT SHOWN

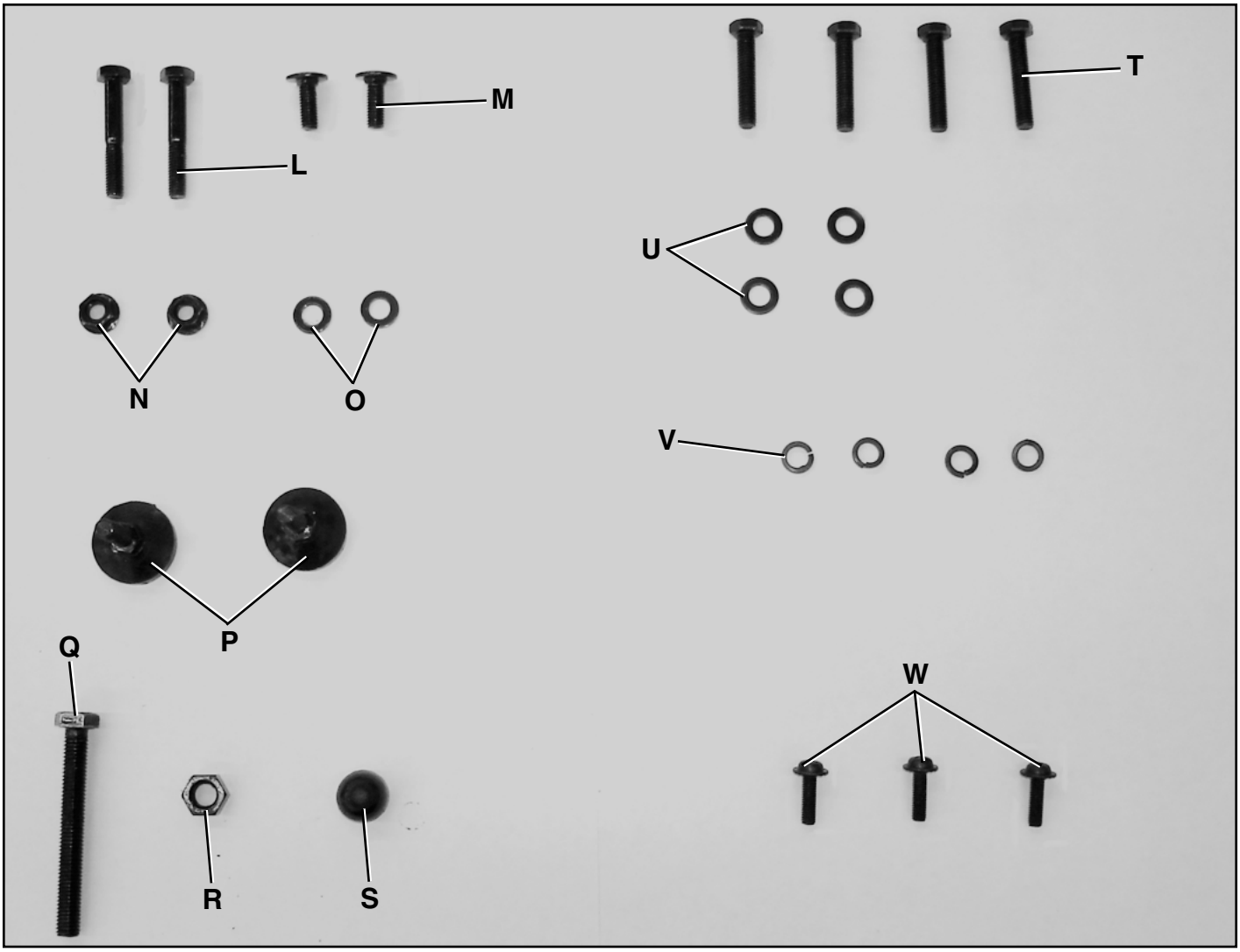
M5 x 8mm pan head screw (1)

M5 x 12mm hex socket head cap screws (2)

M5 lock washer (2)

Wire clip (1)





BANDSAW HARDWARE

L. M8 x 50mm Hex Head Screw (2)

M. M8 x 20mm Carriage Bolt (2)

N. M8 Flange Nut (2)

O. M8 Flat Washer (2)

P. Leveling Feet (2)

Q. Motor Tensioning Bolt (M10 x 100mm)

R. M10 Hex Nut

S. Damping Washer

T. M8 x 40 mm Hex Head Screw (4)

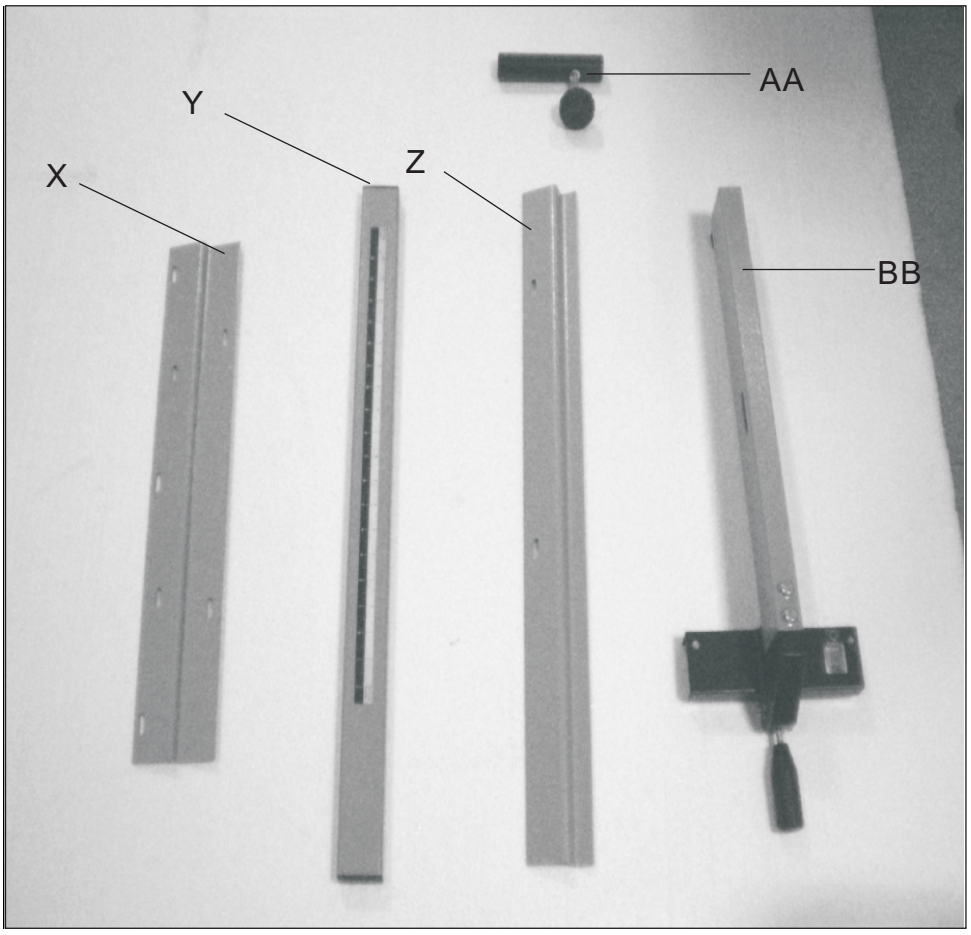
U. M8 Flat Washer (4)

V. M8 Lock Washer (4)

W. Pan Head Flange Screw (3)

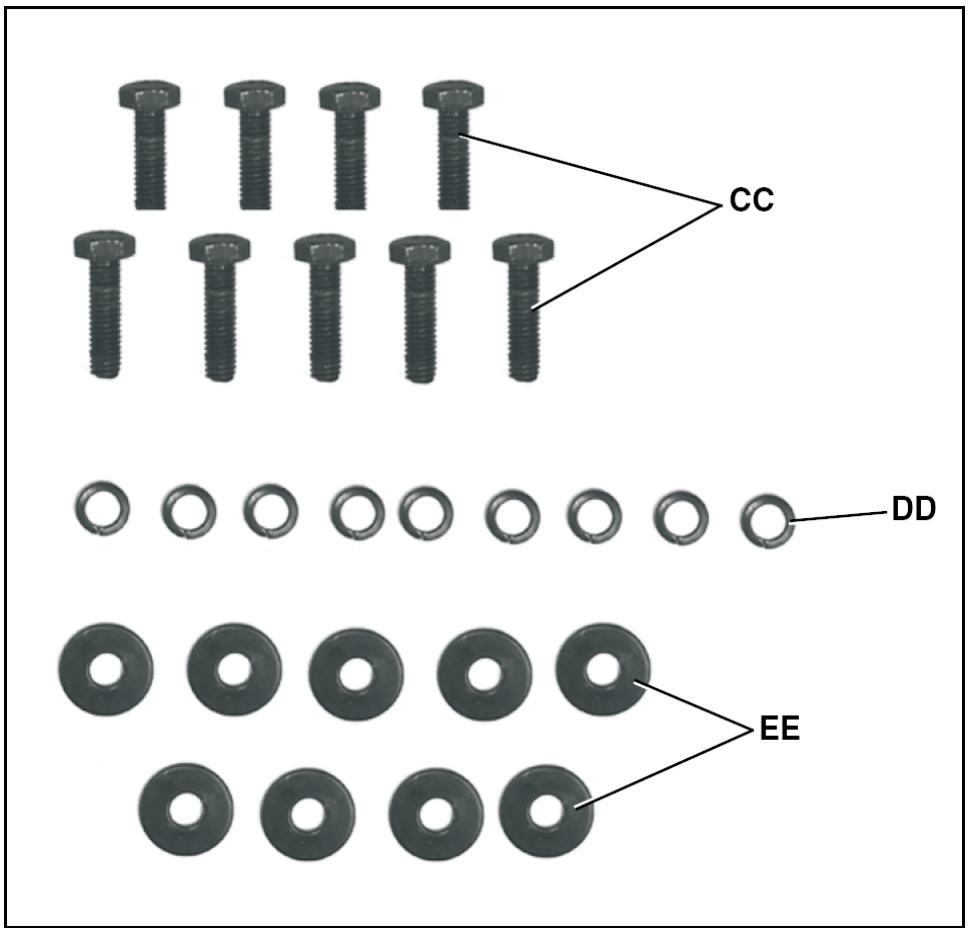
FENCE PARTS

X. Rear Rail
Y. Guide Tube
Z. Front Rail
AA. Resaw Post Assembly
BB. Fence



FENCE HARDWARE

CC. M6 X 25mm Hex Head Screw (9)
DD. M6 Lock Washer (9)
EE. M6 Flat Washer (9)



ASSEMBLY

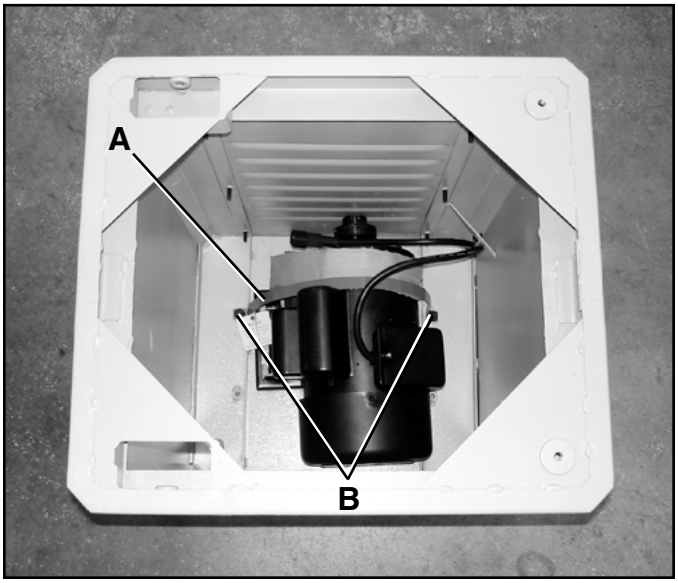
REMOVING MOTOR STRAP

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

The Motor Strap (A) is required for shipping purposes, and must be removed prior to operating the bandsaw. The strap can be removed by loosing the two bolts (B) that fasten the strap using a 13mm wrench or socket. **SEE FIG. 1.**

Fig. 1



ATTACHING MOBILE BASE

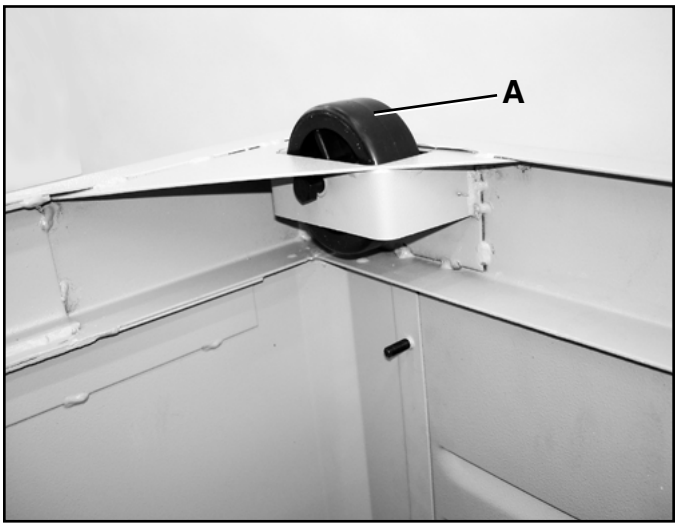
⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

The mobile base consists of one rotating adjustable caster wheel and two stationary wheels that allows you to move the bandsaw around your shop with ease. To install:

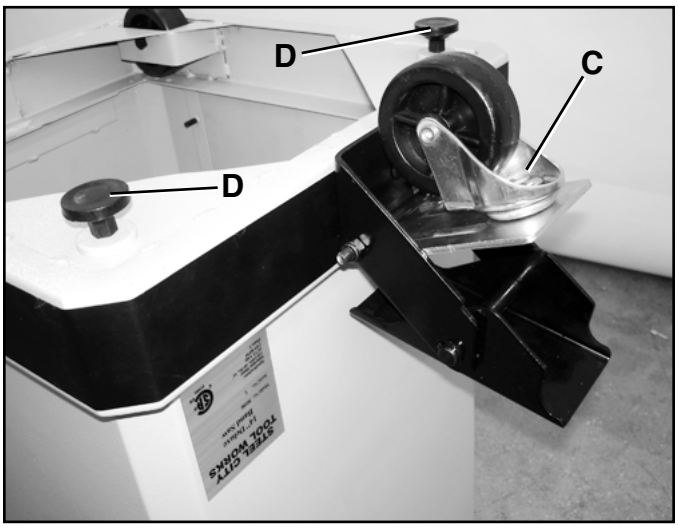
1. Fasten the stationary wheel (A) to the wheel well in the corner of the base using one M8 x 50mm Hex head screw and one M8 flat washer. Repeat this step for the second stationary wheel. **SEE FIG. 2.**

Fig. 2



2. Fasten the caster wheel assembly (C) to the base using the two M8 x 20mm Carriage Bolts and two M8 Flange Nuts. **SEE FIG. 3.**

Fig. 3



3. Attach the leveling feet (D) by screwing the studs into the threaded holes in the bottom of the base
4. Turn the mobile base right side up and make sure that the base does not wobble or rock. If it does, adjust the leveling feet up or down until the unit is stable.

⚠ CAUTION

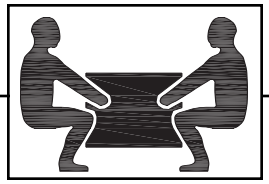
Take care to support the motor when turning the base right side up. Failure to do so can cause the motor to slam into the side of the cabinet damaging the motor, cabinet or both.

ATTACHING BANDSAW TO BASE

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

⚠ WARNING

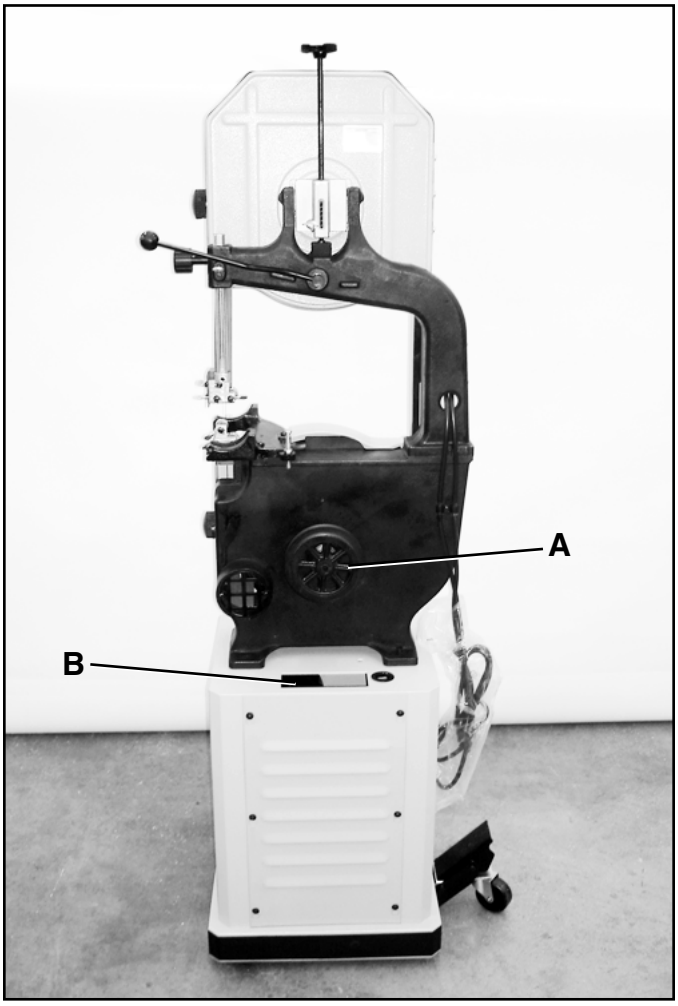


The bandsaw is very heavy. Two people are required for this step.

1. Place the bandsaw on top of the base making sure to line up the four holes in the base with the four holes in the casting of the bandsaw.

NOTE: When placing the bandsaw on the base, make sure that the exposed pulley (A) and the cutout (B) in the base are on the same side. **SEE FIG. 4.**

Fig. 4



2. Fasten the bandsaw to the base using four M8 x 40mm Hex head screws, four M8 flat washers, and four M8 lock washers.

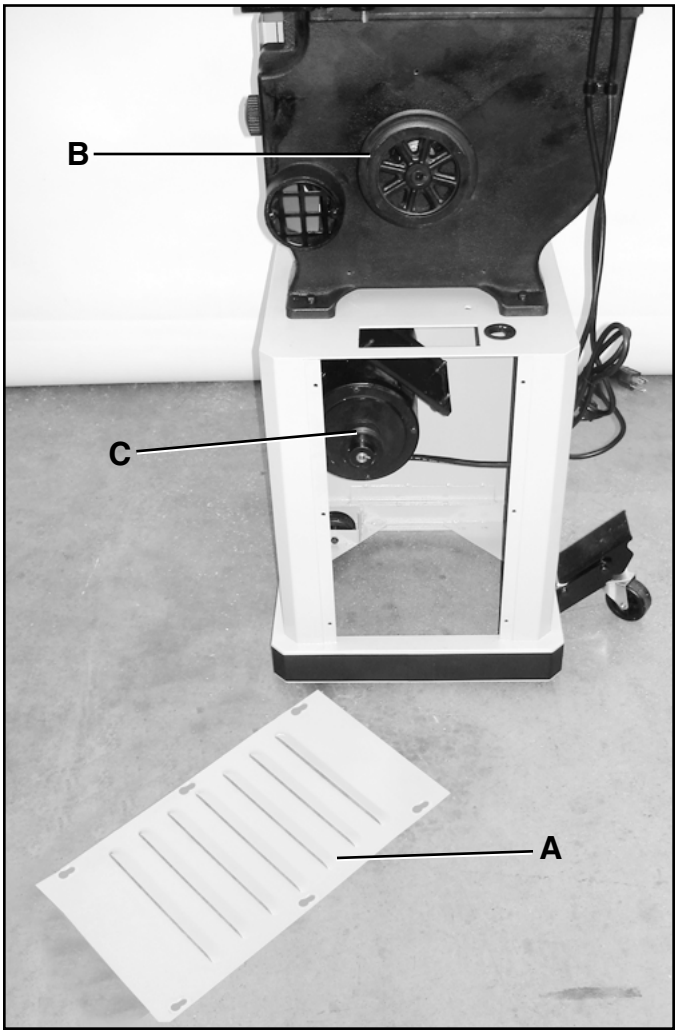
INSTALLING BELT AND BELT GUARD

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Remove the access panel (A) from the base. **SEE FIG. 5.**

Fig. 5

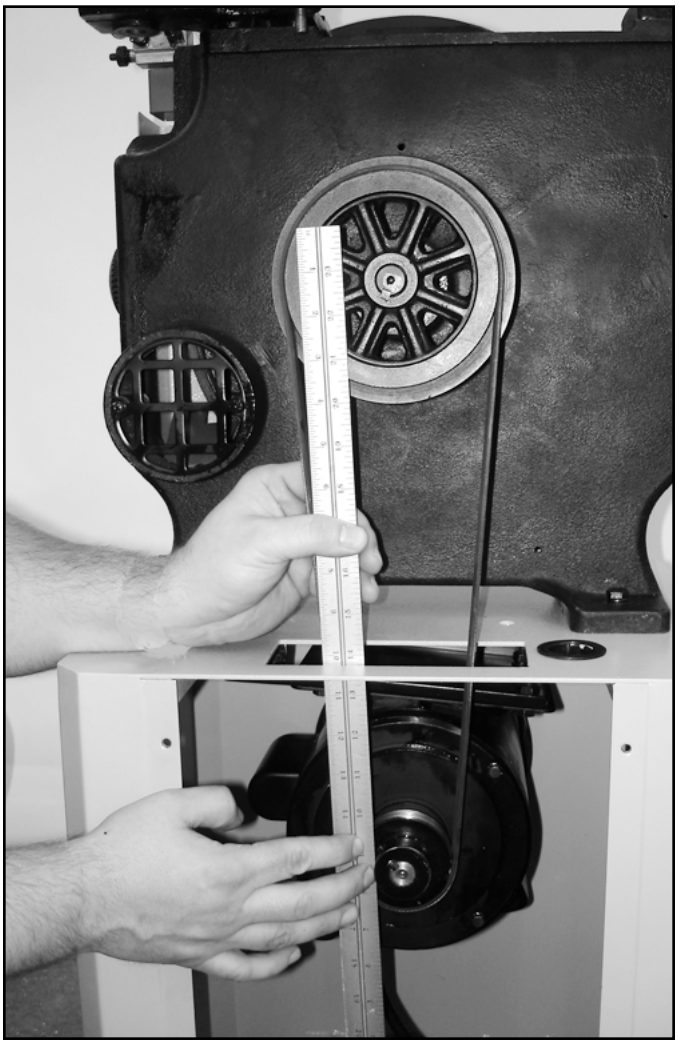


2. Install Belt by “walking” the belt onto the Bandsaw pulley (B) and the Motor pulley (C).

NOTE: There are 2 steps on both the motor pulley and the bandsaw pulley. Installing the belt on the smaller step of the motor pulley and on the larger step of the bandsaw pulley will cause the blade to run at 1500 SFPM, while placing the belt on the larger step of the motor pulley and the smaller step of the bandsaw pulley will cause the blade to run at 3000 SFPM.

3. Once the belt is installed, confirm that the pulleys are aligned using a straight edge on the outer face of both pulleys. If an adjustment is necessary, the motor itself can be repositioned by loosening the four bolts that attach the motor to the motor plate, repositioning the motor, and then retightening the four bolts. **SEE FIG. 6.**

Fig. 6

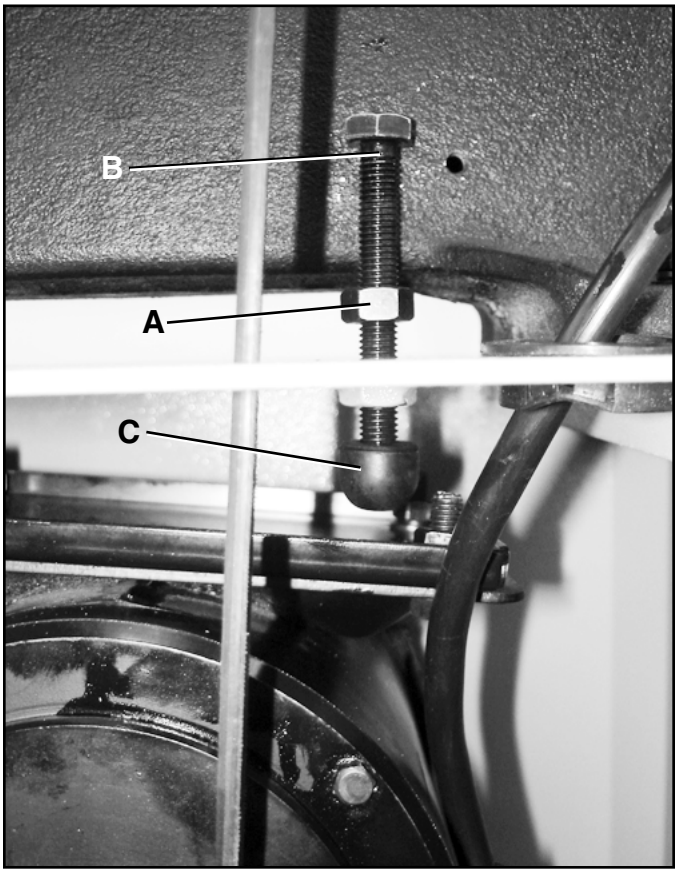


4. Install one M10 Hex Nut (A) onto the motor tensioning bolt (B) and thread the bolt into the base of the bandsaw. **SEE FIG. 7.**

5. Once the tensioning bolt is installed, push the dampening washer (C) onto the end of the bolt.

6. Tighten the motor tensioning bolt until the dampening washer comes in contact with the motor plate. Continue tightening until there is about 1" deflection in the belt when squeezed at its midpoint. Once the correct belt tension is achieved, tighten hex nut from step 4 until it bottoms out against the base.

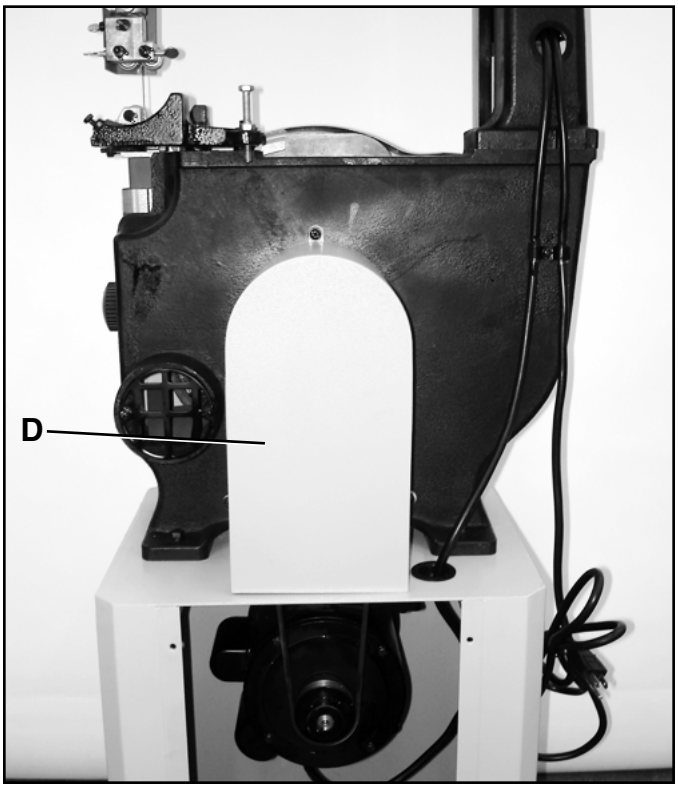
Fig. 7



7. Fasten the pulley cover (D) to the bandsaw using the three pan head flange screws. **SEE FIG. 8.**

8. Reinstall access panel removed in Step 1.

Fig. 8



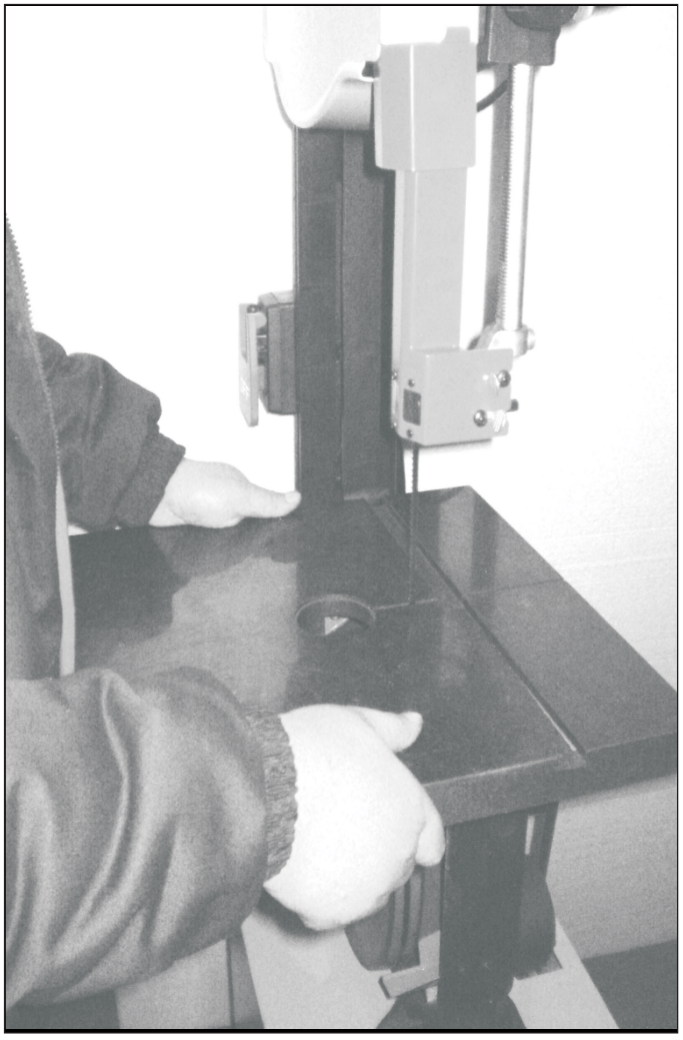
MOUNTING THE TABLE

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Feed the blade through the slot in the table. **SEE FIG. 9**

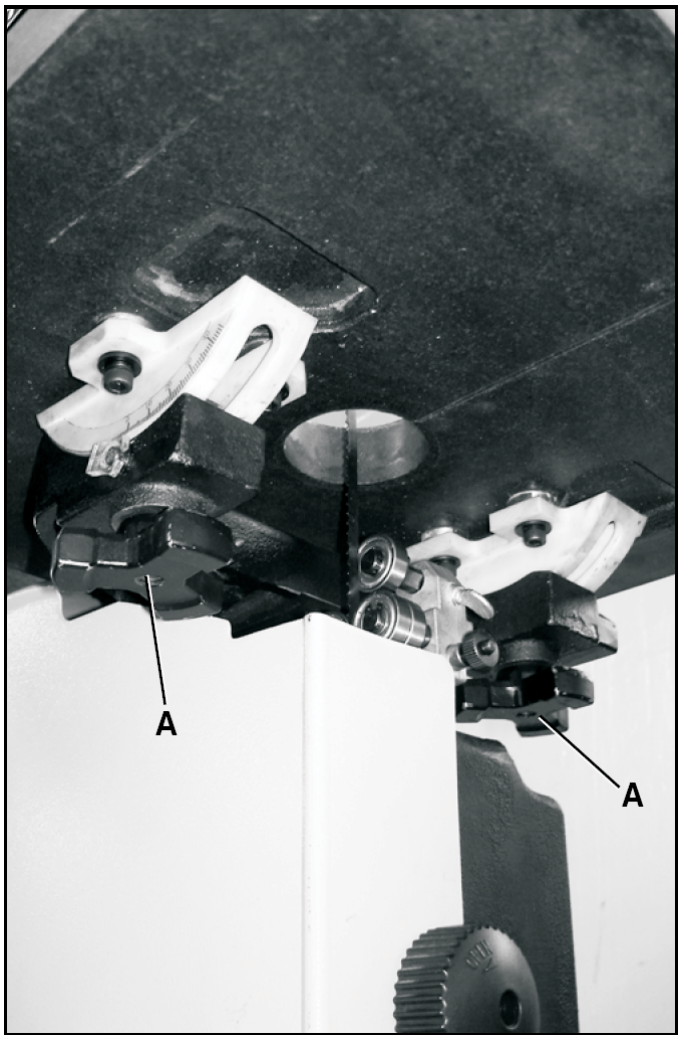
Fig. 9



2. Once the blade reaches the center hole of the table, rotate the table 90 degrees clockwise so that the miter slot is towards the right of the machine

3. Position the two threaded bolts so that they line up with the holes in the trunnion. Once the bolts are through the holes, fasten the table using the two table lock knobs (A). **SEE FIG. 10.**

Fig. 10



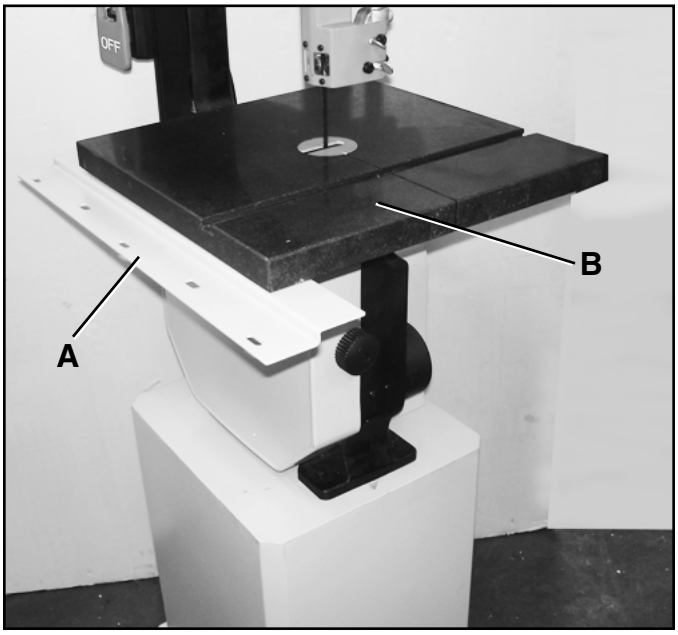
RAIL ASSEMBLY

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

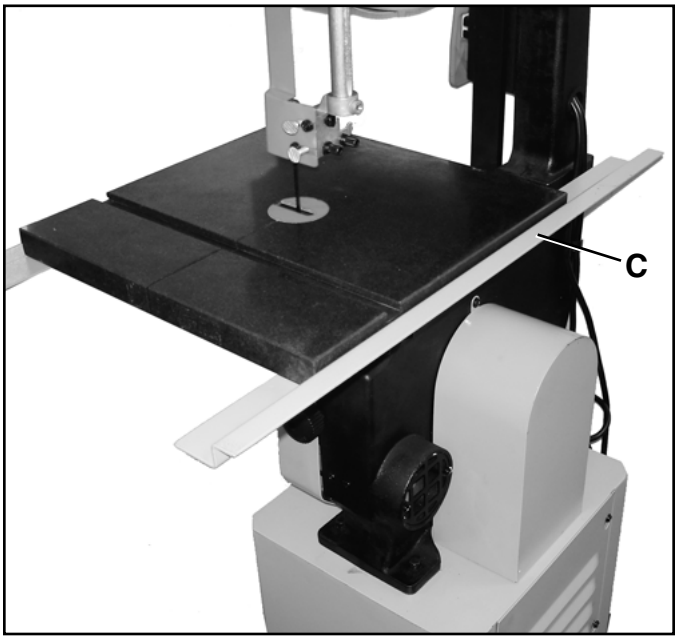
1. Attach the Front Rail (A) to the underside of the Granite Table (B) using two M6 x 25mm Hex Head Screws, two M6 Lock Washers, and two M6 Flat Washers. **SEE FIG. 11.**

Fig. 11



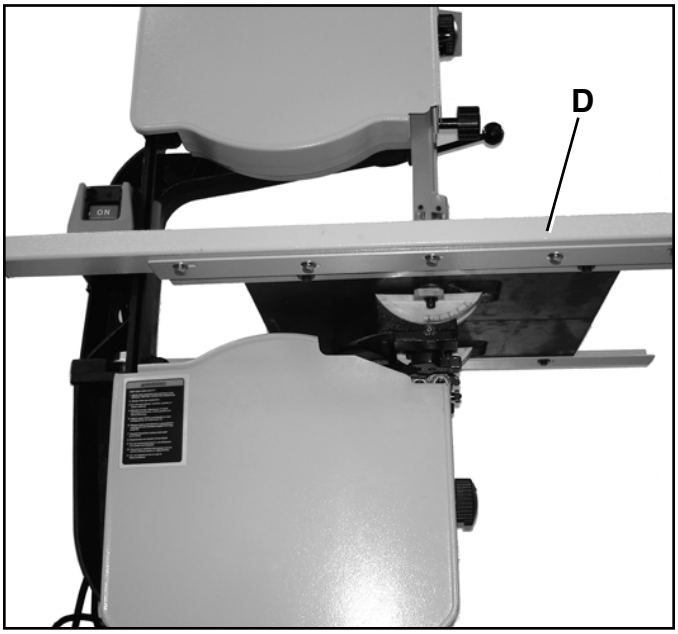
2. Attach the Rear Rail (C) to the rear of the table using two M6 x 25mm Hex Head Bolts, two M6 Lock Washers, and two M6 Flat Washers. **SEE FIG. 12.**

Fig. 12



3. Fasten the Guide Tube (D) to the Front Rail using five M6 x 25mm Hex Head Screws, five M6 Lock Washers, and five M6 Flat Washers. Try to center the screws in the slots of the front rail. Snug up the screws, but do not fully tighten at this time **SEE FIG. 13.**

Fig. 13



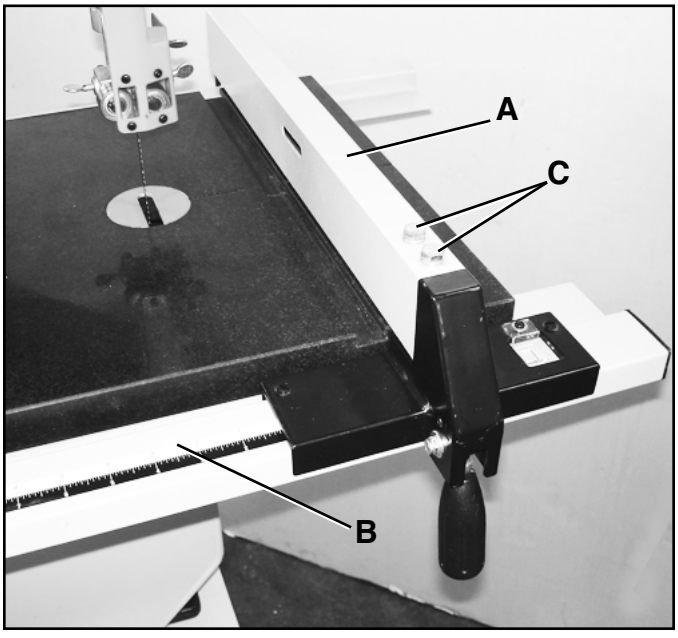
FENCE ADJUSTMENT

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Place the Fence (A) onto the Guide Tube (B). Make sure that the hook on the rear of the Fence fits under the Rear Rail. **SEE FIG. 14.**

Fig. 14

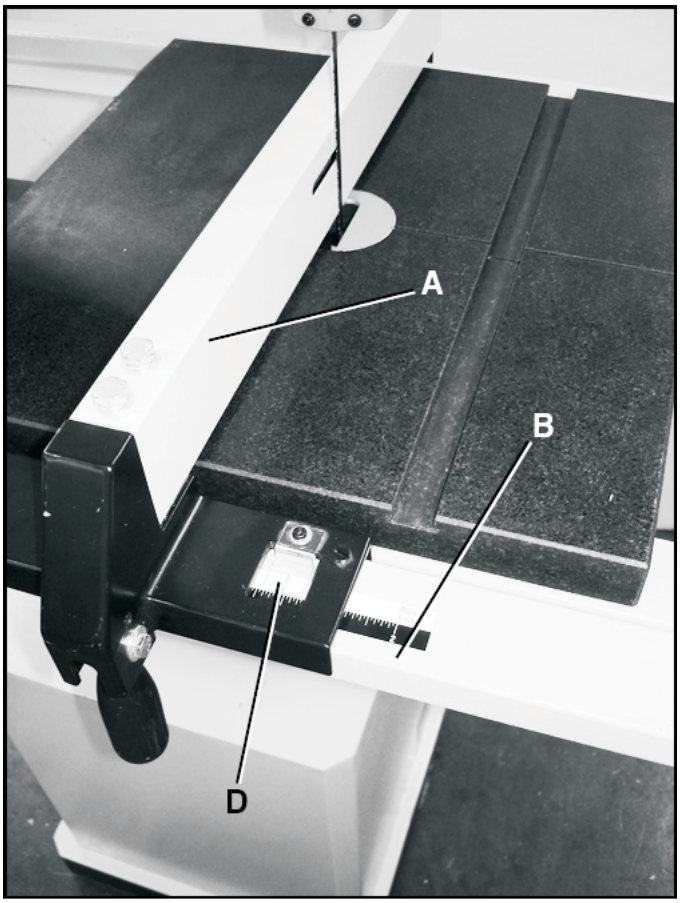


2. Align the left side of the Fence Body with the right edge of the Miter Slot in the Granite Table. Push down on the Fence Handle to lock the fence in place.

3. The fence body should align parallel with the Miter Slot. If an adjustment is necessary, loosen the two Hex Bolts (C) in the top of the Fence Body and shift the Fence Body until it is parallel with the Miter Slot. Retighten the two Hex Bolts. **SEE FIG. 14, pg. 23.**

4. Remove the Fence (A) and reposition it on the Guide Tube (B)so that the Cursor (D) lines up with the Zero mark on the scale. Lock the fence down. **SEE FIG. 15.**

Fig. 15



NOTICE: The scale is divided into upper and lower sections. When performing this step BE SURE to align the Cursor with the Zero mark on the lower scale. The upper scale is for use with the Resaw Post, which will be discussed later in this manual.

5. With the Fence locked down, loosen the five M6 x 15mm Screws that fasten the Guide Tube to the Front Rail and reposition the Guide Tube until the Fence just touches the blade. Securely tighten the five M6 x 25mm Screws.

NOTICE: Do not force the Fence into the blade so that it bends. The fence should just touch the blade.

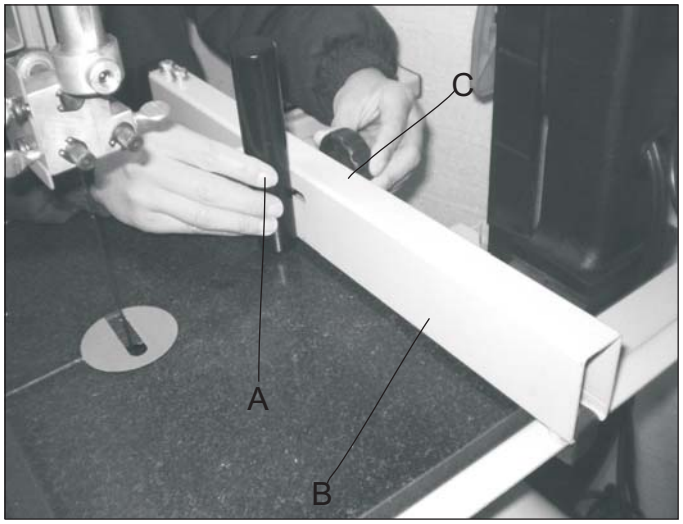
ATTACHING RESAW POST

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Attach the Resaw Post (A) to the Fence (B) by threading the Lock Knob (C) through the Fence and fastening it to Resaw Post. **SEE FIG. 16.**

Fig. 16

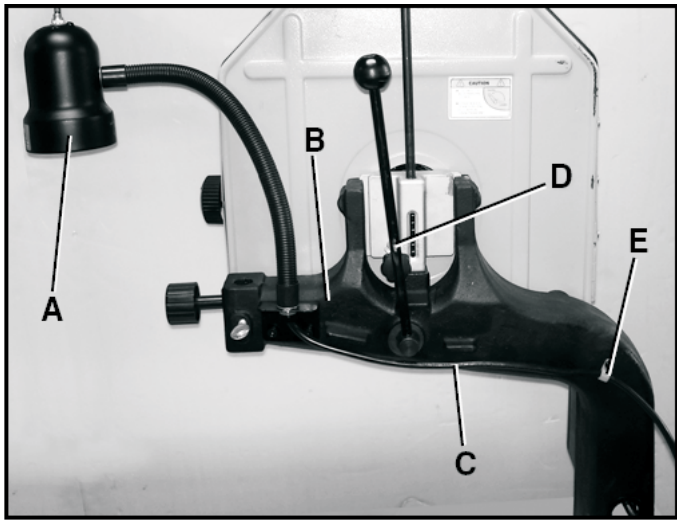


2. Position the Post so that it is centered with the front edge of the blade and tighten Knob securely.

ATTACHING WORK LAMP

1. The Work Lamp (A) attaches to the Cast Iron Frame (B) of the Bandsaw, using two M5 x 12mm Socket Head Cap Screws and two M5 lock washers. **SEE FIG. 16A.**

Fig. 16A



2. Once the Lamp is fastened in place, run the Power Cord (C) so that is sits below the Cam Lever (D).

3. Fasten the Power Cord in place using the Wire Clip (E). The Wire Clip is held in place using one M5 x 8mm Pan Head Screw.

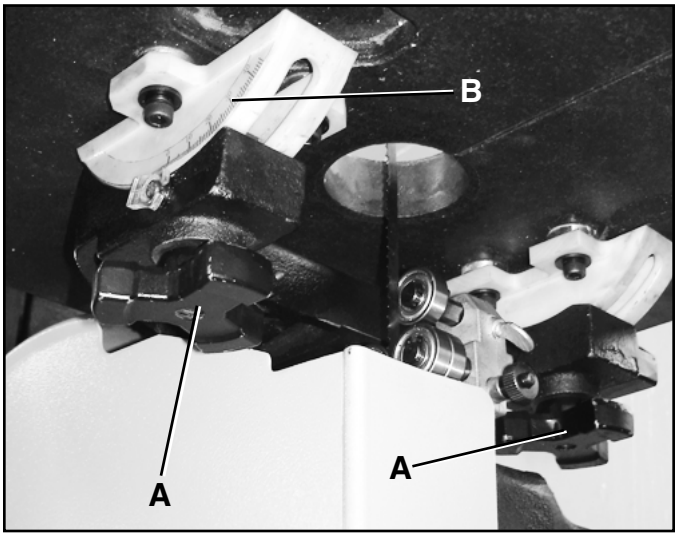
ADJUSTMENTS

TABLE TILT

The table on your bandsaw is designed to tilt up to 45 degrees to the right and up to 3 degrees to the left. To tilt the table:

1. Loosen both lock knobs (A) on the underside of the table. **SEE FIG. 17.**

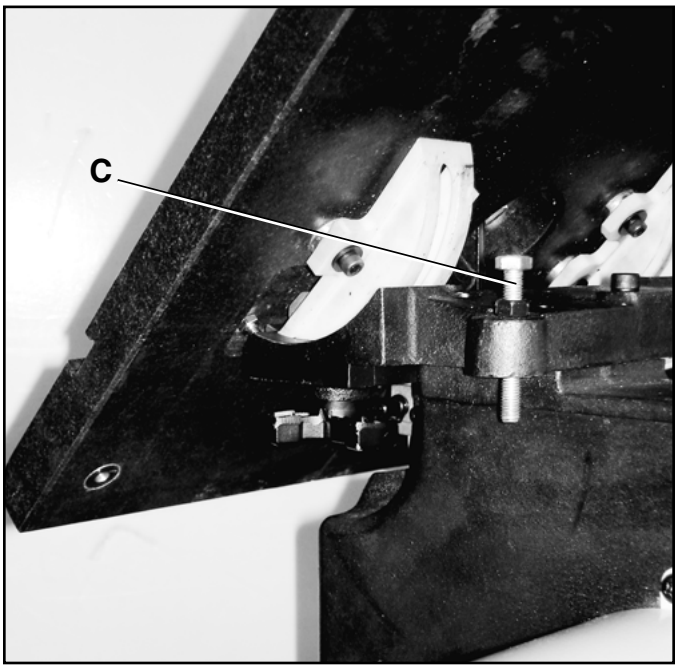
Fig. 17



2. Tilt the table to the right noting that the scale (B) shows the angle of the table.
3. Retighten lock knobs when desired angle is achieved.

NOTE: In order to tilt the table to the left, it is necessary to remove the positive stop bolt (C) **SEE FIG. 18.**

Fig. 18



SETTING BLADE TENSION

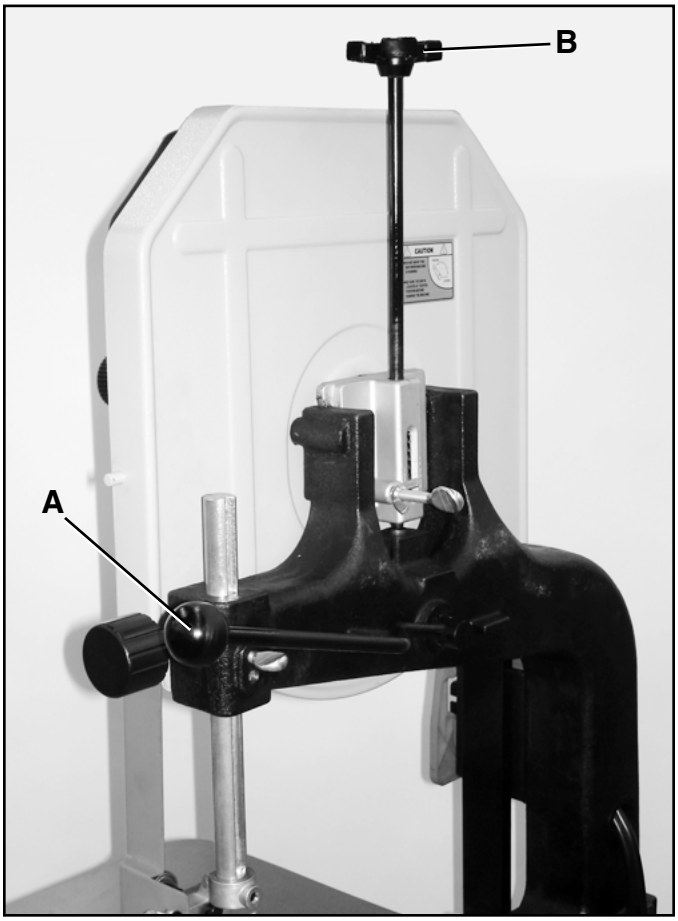
The blade tension is set by using the blade tension knob. It **MUST** be set prior to initial operation as it plays a vital role in setup of other features of the bandsaw. It should also be checked when the blade is replaced, and from time to time as the blade will stretch after prolonged use. Keep in mind that putting too much or too little tension can cause either blade breakage (too much pressure) or poor cutting results (too little pressure).

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

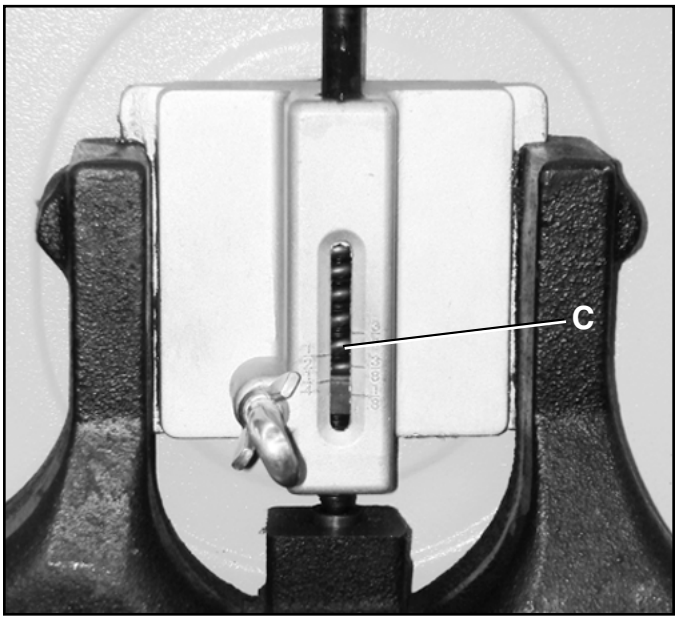
1. Loosen the tension on the blade by rotating the cam lever (A) clockwise. **SEE FIG. 14.**
2. Set the blade tension by rotating the knob (B). Turning the knob clockwise increases the tension while turning the handwheel counterclockwise decreases the tension.

Fig. 19



3. As you rotate the knob you will notice a red marker (C) on the inside of the scale. This is to be used as a guideline for the blade tension depending on the width of the blade. For example if you are using a 1/8" blade, align the red marker inside the scale with the 1/8" mark on the outside of the scale. **SEE FIG. 20.**

Fig. 20



NOTE: The scale is only a recommended guideline for tensioning. Always follow the blade manufacturer's recommendations for proper blade tension.

NOTE: When the bandsaw is not in use, it is a good idea to release the tension on the blade using the cam lever.

BLADE TRACKING

Blade tracking refers to the way the saw blade rides on the wheels while the machine is in operation. This adjustment has been set at the factory, but it is good practice to check the tracking each time before using the machine. Tracking should also be checked after a blade change.

⚠ WARNING

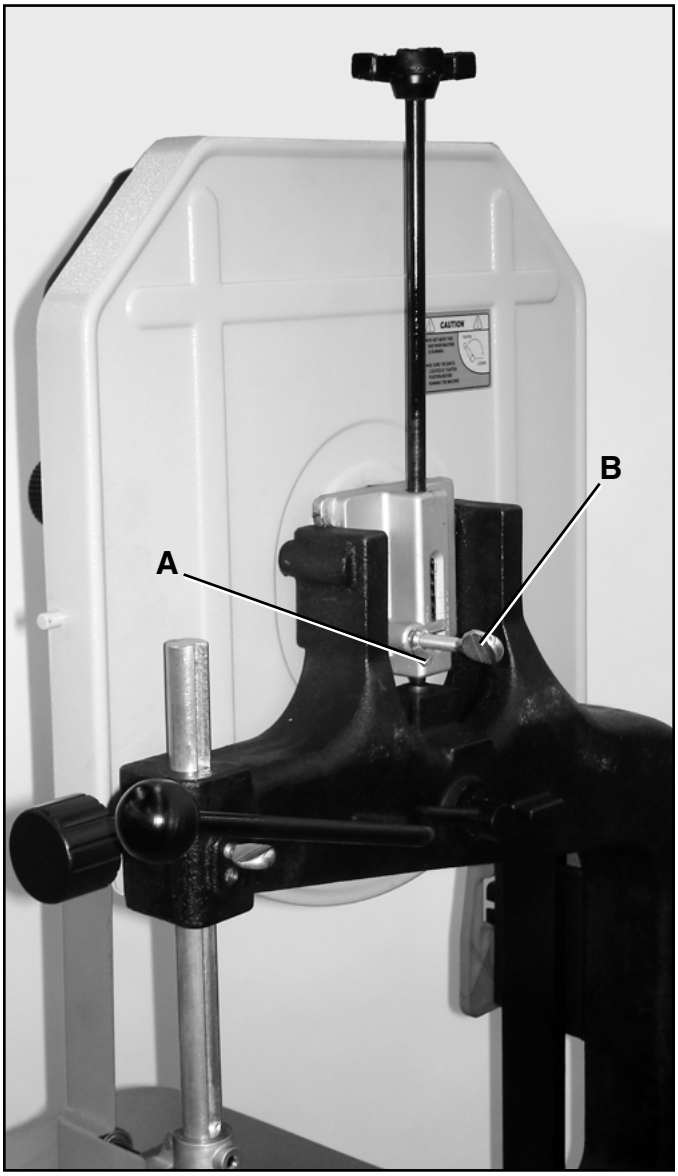
MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Open the upper door exposing the top wheel of the bandsaw.

2. Rotate the wheel clockwise, by hand, and take note of the position of the blade on the wheel. The blade should ride on the center of the wheel.

3. If the blade does not ride on the center of the wheel, or starts to move towards the edge of the wheel, loosen the wingnut (A) and turn the tracking adjustment knob (B). **SEE FIG. 21.**

Fig. 21



NOTICE: When using the tracking adjustment knob, do so in small increments as this is a sensitive adjustment.

4. Rotate the wheel again. Repeat steps 2 through 4 until the blade rides on the center of the wheel.

5. Once proper tracking is achieved, close and secure the upper door and retighten wing nut loosened in step 3.

ADJUSTING TABLE POSITIVE STOPS

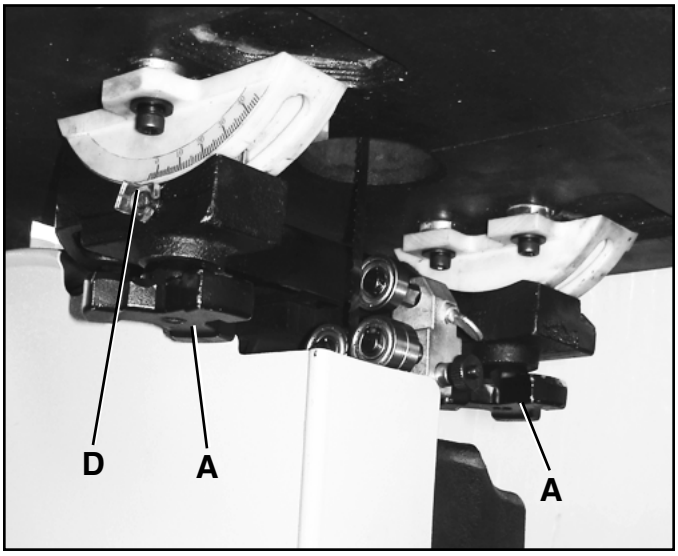
⚠CAUTION

DO NOT attempt to set the positive stops until you have checked and/ or adjusted both the blade tension and blade tracking. Refer to SETTING BLADE TENSION and BLADE TRACKING in the ADJUSTMENTS section of this manual.

SETTING 90 DEGREE STOP

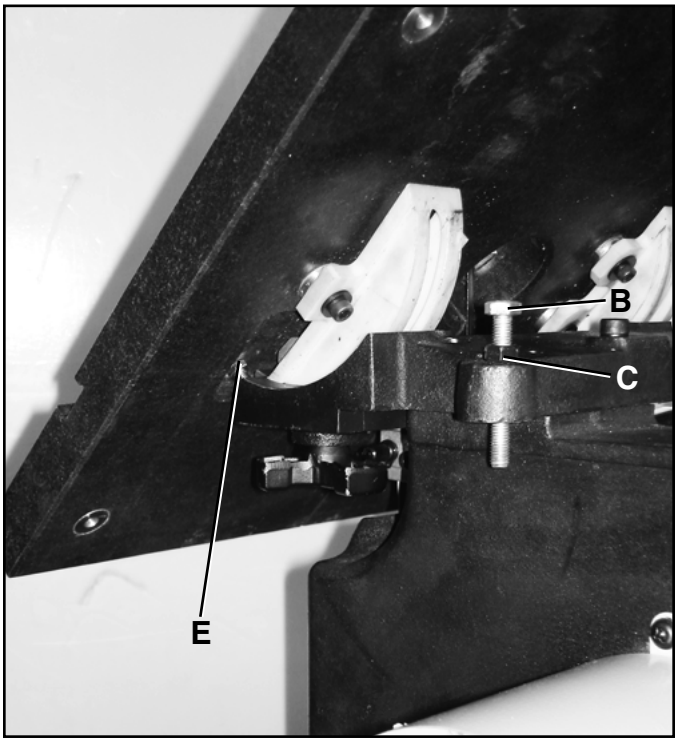
1. Loosen both table locking knobs (A). **SEE FIG 22**.

Fig. 22



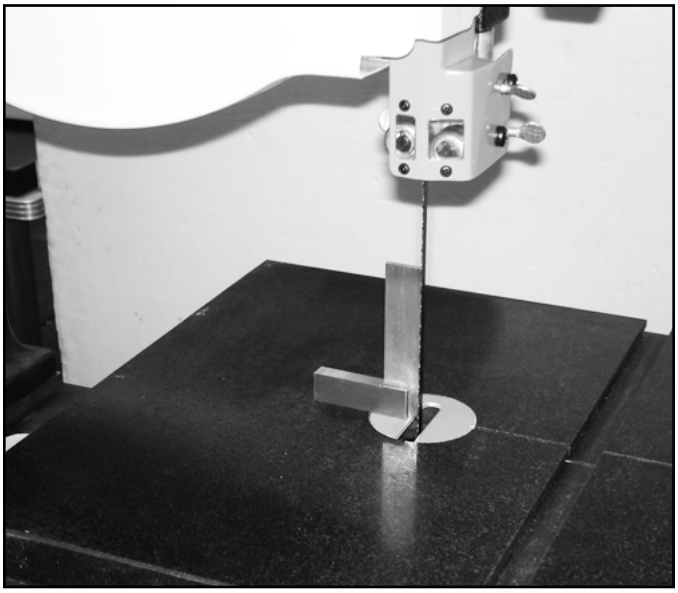
2. Let the table rest against the 90 degree stop (B). **SEE FIG. 23.**

Fig. 23



3. Place a square on the tabletop and up against the saw blade. **SEE FIG. 24.**

Fig. 24



4. If an adjustment is necessary, tilt the table until it is square to the blade and tighten the two lock knobs.

5. Loosen Hex Nut (C) and adjust the 90 degree positive stop (B) until it contacts the underside of the table. Retighten Hex Nut. **SEE FIG. 24.**

6. Adjust pointer on the bevel scale (D) to read zero, if necessary. **SEE FIG. 23.**

SETTING 45 DEGREE STOP

1. Loosen the table lock knobs (A). **SEE FIG. 22.**

2. Tilt the table until the pointer on the bevel scale lines up at the 45 degree mark.

3. The 45 degree positive stop (E) should contact the table at this point. **SEE FIG. 24.**

4. If an adjustment is necessary, loosen the hex nut on the 45 degree stop and adjust stop until it contacts the table when the bevel scale reads 45 degrees.

5. Once the stop is set, retighten the hex nut.

UPPER BEARING ADJUSTMENT

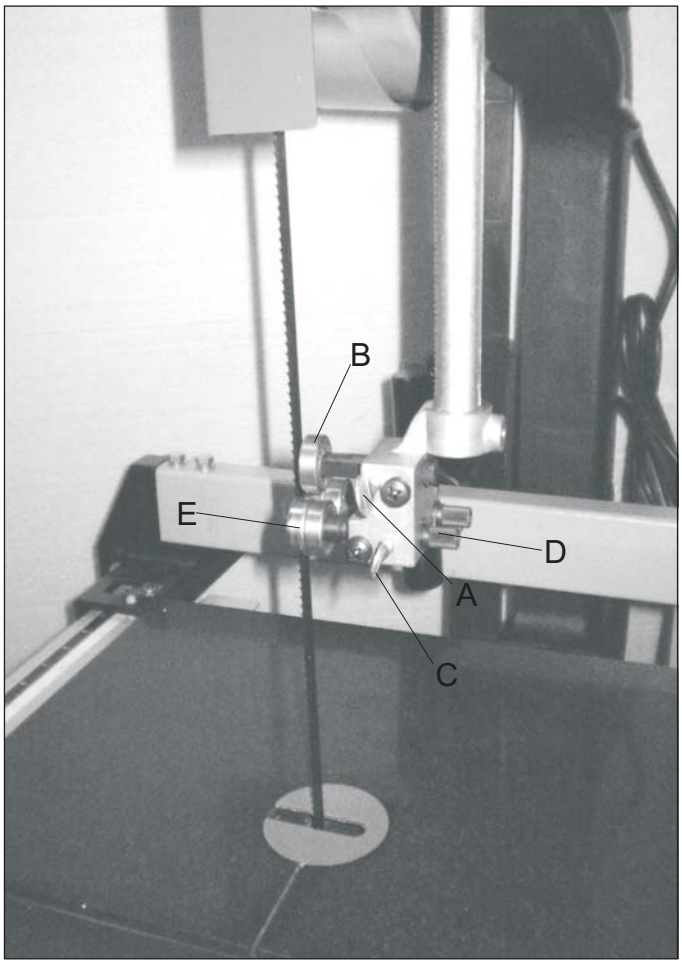
NOTICE: Make certain that you have followed all of the steps in the SETTING BLADE TENSION section in the ADJUSTMENTS section of this manual prior to starting this section.

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Loosen thumbscrew (A) and slide thrust bearing (B)until it is within .003 of the saw blade. This Is equivalent to about the thickness of a dollar Bill. Once the thrust bearing is set, retighten thumbscrew. **SEE FIG. 25.**

Fig. 25



2. The guide bearings (E) should be positioned within 1/32" of the blade. If an adjustment is necessary, loosen thumbscrew (C) and adjust knob (D) until the guide bearing is within 1/32" of the blade. Use this process for the left and right guide bearings.

3. Once guide bearings and thrust bearing are set, make certain that all thumbscrews are retightened.

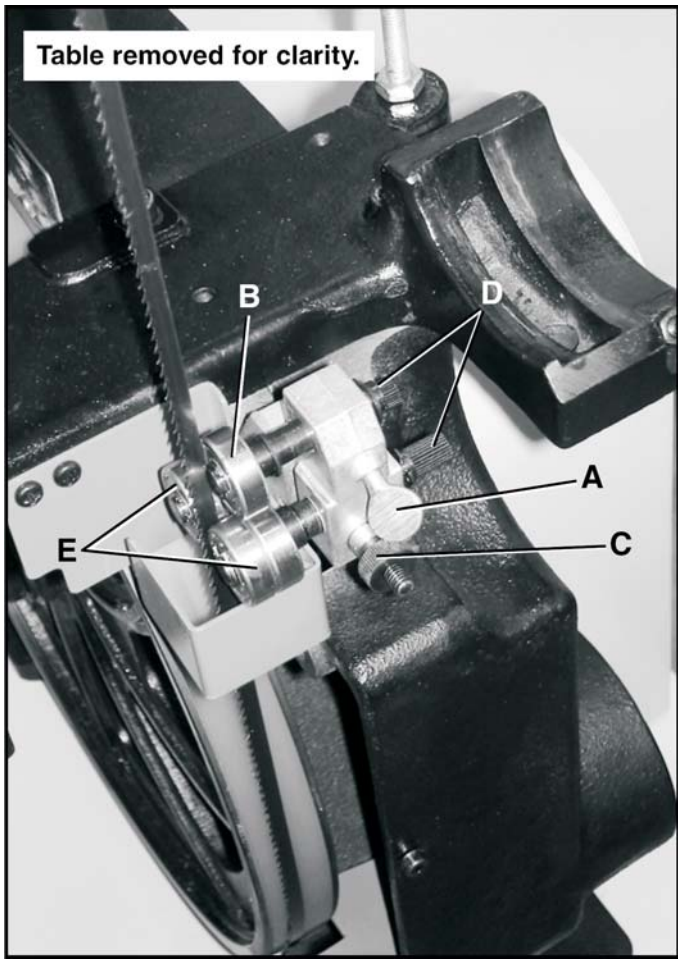
LOWER BEARING ADJUSTMENT

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Loosen Thumbscrew (A) and slide thrust bearing (B) until it is within .003 of the saw blade. Again, this is about the thickness of a dollar bill. Once the thrust bearing is set, retighten thumbscrew. **SEE FIG. 26.**

Fig. 26



2. The guide bearings (E) should be positioned within 1/32" of the saw blade. If an adjustment is necessary, loosen thumbwheel (C) and adjust knobs (D)until each guide bearing is within 1/32" of the blade. Each Guide Bearing (E) is controlled separately by the knob (D) directly behind it.

NOTE: When setting the guide bearings, make sure that the bearings do not extend past the set of the blade.

3. Once guide bearings and thrust bearing are set, make certain that all thumbscrews and thumbwheels are retightened.

BELT TENSION

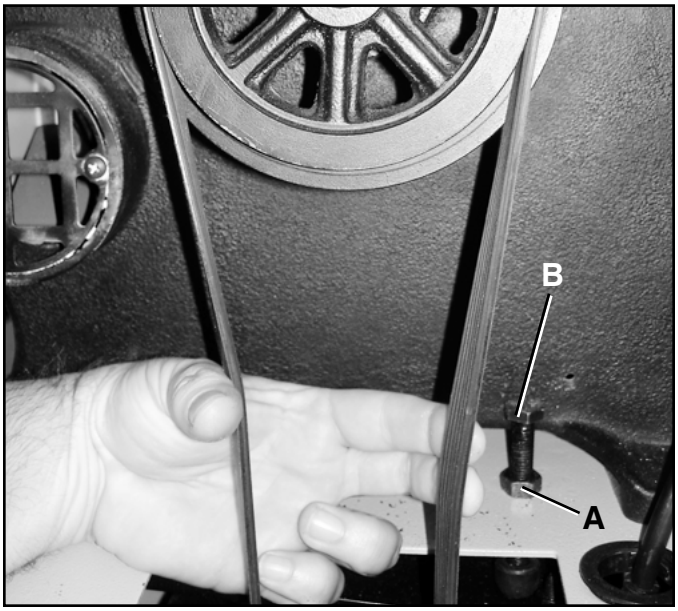
Belt tension is adjusted using the Motor Tensioning Bolt. It should be adjusted on initial setup and when the belt is replaced. It should also be checked periodically as the belt may stretch after time. Correct belt tension is achieved when there is 1" or less deflection in the belt when squeezed at it's midpoint.

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. To adjust the belt tension, first remove the pulley cover by removing the three Phillips head screws that fasten it to the bandsaw.
2. Check belt tension by squeezing it at the point just where it exits the base. **SEE FIG. 27.**

Fig. 27



3. If an adjustment is necessary, loosen Hex Nut (A) and Tighten Motor Tensioning Bolt (B). until the proper tension is achieved.
4. Once the correct tension is achieved, retighten Hex Nut.

BLADE DRIFT

Blade drift occurs when the blade begins to wander off the cutting line. It can be caused by several factors.

- Incorrect Blade Tension
- Wrong Blade Type
- Dull Blade

If you experience blade drift, check the appropriate adjustments first. If this does not correct the problem, the blade may have to be replaced. See BLADE REPLACEMENT in the MAINTENANCE section of this manual for more information.

CHANGING MOTOR VOLTAGE

The motor supplied with your bandsaw is a dual voltage 115 / 230V motor. The motor comes prewired from the factory for 115 volt operation. To change to 230 volt operation, in addition to the following steps, it is necessary to replace the existing 115V plug with a UL/CSA listed plug(not included) suitable for 230V and the rated amperage of the motor. The saw should only then be connected to an outlet having the same configuration as the plug. No adapter is available or should be used with a 230V plug.

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Remove the junction box cover from the motor and follow the wiring diagram on the inside of the cover for 230V operation.
2. Replace junction box cover.
3. The START / STOP switch does **NOT** need to be modified.

CHANGING BLADE SPEED

This Bandsaw is designed to run at either 1500 SFPM (square feet per minute) or 3000SFPM. Which speed the blade runs at is determined by which set of pulleys the Drive belt rests on. If the Belt is installed on the smaller step of the Motor Pulley and the larger step of the Saw Blade Pulley, the Blade will turn at a rate of 1500 SFPM. Conversely, with the Belt on the larger step of the Motor Pulley and the smaller step of the Saw Blade Pulley will cause the blade to run at 3000SFPM. To change speeds

1. Loosen Hex Nut (A) and loosen Motor Tensioning Bolt (B). This will give you the slack you need in order to reposition the belt. **SEE FIG. 27.**
2. Move the belt by "walking the belt" onto the set of pulleys that will provide the desired speed.
3. Once the belt is in place, retighten the Motor Tensioning Bolt and secure the Bolt by retighten the Hex nut.

NOTICE : It is recommended to follow the step in the BELT TENSION section in the ADJUSTMENTS section of this manual whenever changing blade speed.

BLADE SELECTION

Using the proper saw blade for the job you are performing will optimize the efficiency of your bandsaw and increase the quality of your work. There are some basic questions that apply when determining which type of blade to use.

- What type of material is to be cut?
- How thick is the workpiece?
- What features does the workpiece contain, i.e. bends, curves, etc.?

These questions will help you with determining which type of blade to use. The type of blade is determined by 5 features. They are:

1. Blade width
2. Pitch
3. Tooth shape
4. Set
5. Blade material

BLADE WIDTH

Blades for the bandsaw are available in different standard widths. This width is measured from the rear of the blade to the tip of the tooth. In general, a wider blade is used for ripping and generally straight line cuts. The narrower blades are mainly used for cutting a workpiece with curves and bends.

PITCH

The unit of measure for pitch is teeth per inch. A fine pitch, meaning having more teeth per inch, will deliver a smoother cut, but will take a longer time to complete. A coarse pitch, meaning having fewer teeth per inch, will cut much faster, but leave a rougher finish. A good rule of thumb is the thicker the workpiece, the coarser the pitch should be.

TOOTH SHAPE

Tooth shapes come in several basic types. Three of them are hook, skip, and variable. Skip and hook types are used to help obtain a higher feed rate when cutting thick workpieces, while variable combines the features of two types of blades.

SET

The term “set” refers to the way that the saw teeth are bent or positioned. Set patterns are selected depending on the type of material being cut.

BLADE MATERIAL

Bandsaw blades can be made from different types of materials. Some common materials are carbon steel, spring steel, and high speed steel.

OPERATIONS

⚠ WARNING

ALWAYS wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

⚠ WARNING

ALWAYS wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

NOTICE

The following section was designed to give instructions on the basic operations of this bandsaw. However, it is in no way comprehensive of every bandsaw application. It is strongly recommended that you read books, trade magazines, or get formal training to maximize the potential of your bandsaw and to minimize the risks.

PRE RUN CHECK

Before you begin using your new bandsaw, you should give it a thorough inspection and ask yourself the fol-lowing questions:

⚠ WARNING

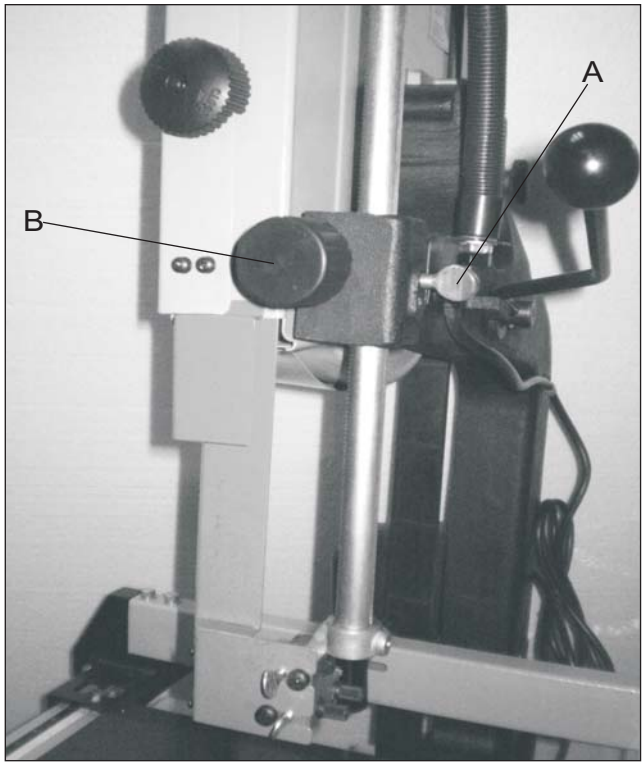
MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Are the blade bearings properly adjusted?
2. Is the blade tension and blade tracking properly set?
3. Is the fence aligned parallel to both the table and the blade?
4. Is the unit stable, does it rock or wobble?
5. Have you read all the warnings associated with this Saw?

BLADE GUARD HEIGHT

The blade guard height is set by loosening the thumbscrew (A) turning the adjustment knob (B). Turning the knob clockwise lowers the guard, while turning it counterclockwise raises the guard. The guard should set no higher than 1/4" above your workpiece during use. **SEE FIG. 28**

Fig. 28



MAINTENANCE

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

GENERAL CLEANUP

- Keep the bearing guides clean and free of buildup of pitch, resin, etc.
- Remove any deposits from the wheels to help avoid vibration and premature blade breakage
- Keep the inside of bandsaw clear of sawdust. Occasionally vacuum out the inside of the unit or blow out the inside of the unit with an air hose.
- Clean and grease the raising /lowering mechanism if the unit becomes difficult to move

INSTALLING / CHANGING BLADES

⚠ WARNING

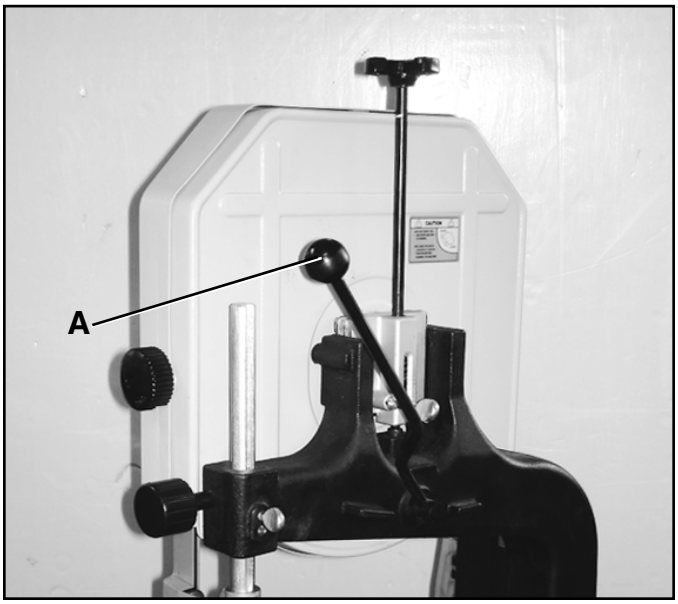
MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Remove the table insert and take the tension off of the blade by rotating the Cam Lever (A) clockwise. **SEE FIG. 29.**
2. Open both the upper and lower doors of the bandsaw.
3. Carefully remove the blade from between the upper and lower guides and remove the blade from both of the wheels. Slide the blade through the slot in the table to remove the old blade.
4. Guide the new blade through the table slot and place into the blade guides and onto the center of the upper and lower wheels.

NOTICE: The blade teeth **MUST** point downward and towards the front of the saw.

5. Replace the table insert.

Fig. 29



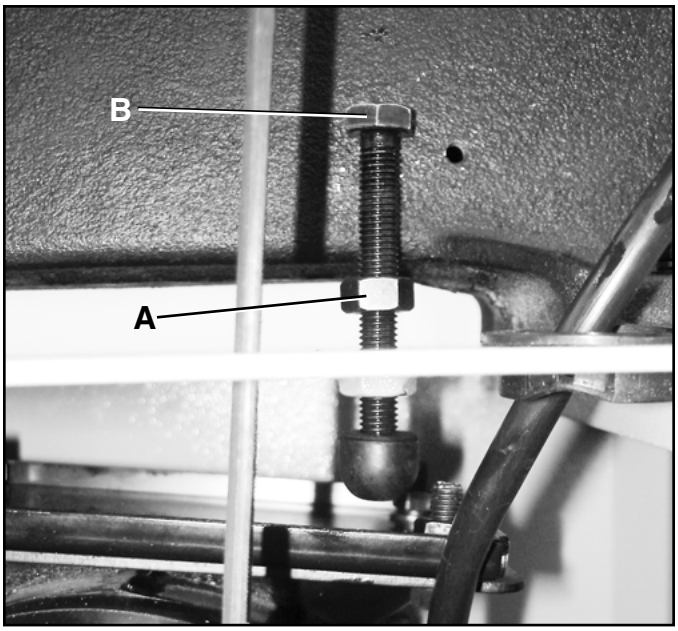
REPLACING POLY-V BELT

⚠ WARNING

MAKE CERTAIN THAT THE SAW IS DISCONNECTED FROM THE POWER SOURCE.

1. Remove the Motor Access Panel and the Pulley Cover.
2. Loosen the M10 Hex Nut (A) and the Motor Tensioning Bolt (B) to take tension off of the belt. **SEE FIG. 30**.

Fig. 30



3. Remove the belt by “walking” the belt off of the upper and lower pulleys.
4. Install the new belt.
5. Tighten down the Motor Tensioning Bolt until the belt deflects no more than 1” when squeezed at its midpoint. Once proper tension is achieved, tighten down the Hex Nut loosened in step 2.
6. Reattach both the Motor Access Panel and Pulley Cover when finished installing the belt.

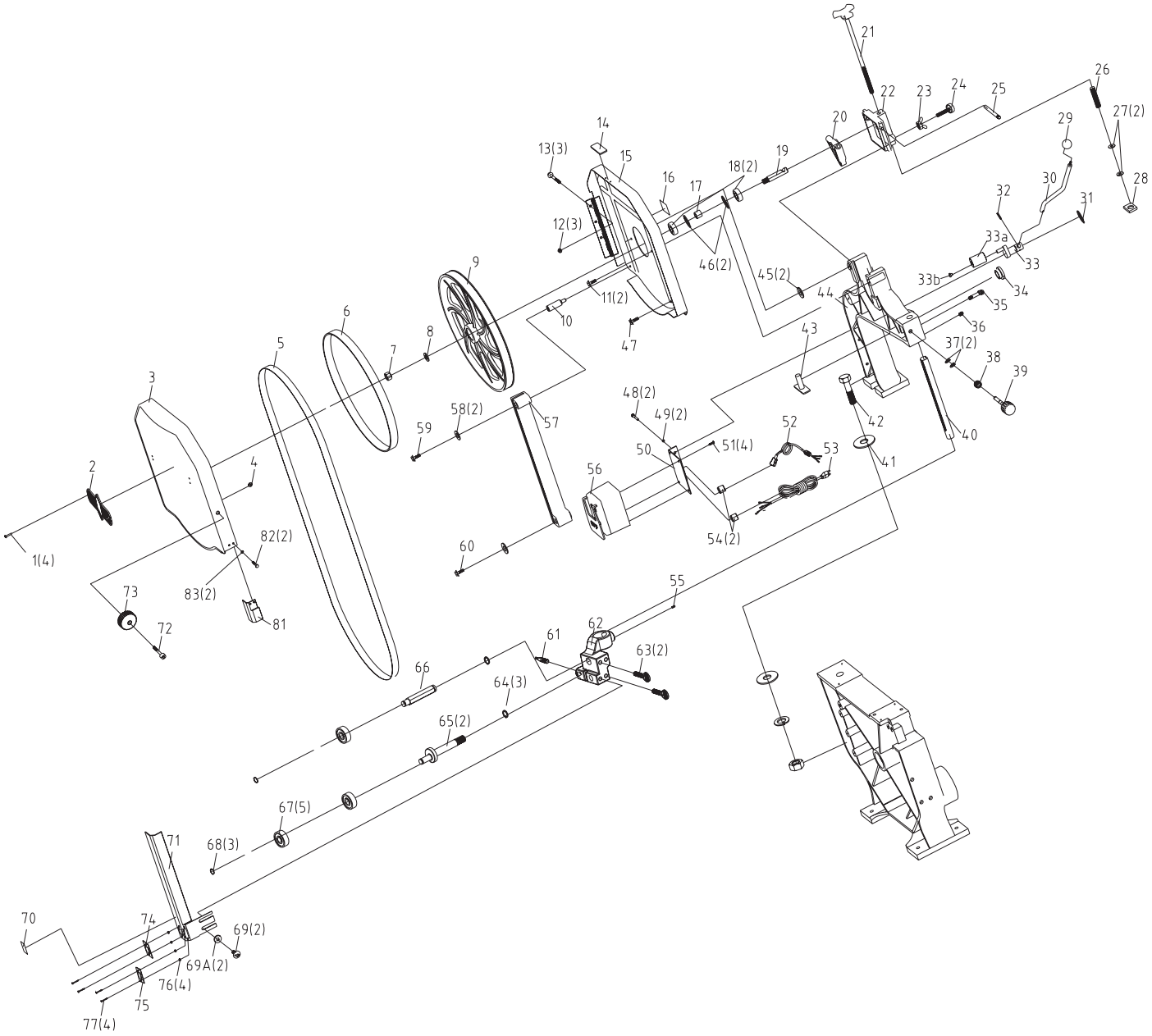
NOTICE: Before operating bandsaw, make sure to go back to the ADJUSTMENTS section of this manual and redo the following sections:

- Setting Blade Tension
- Blade Tracking
- Upper and Lower Guide Bearing Adjustments

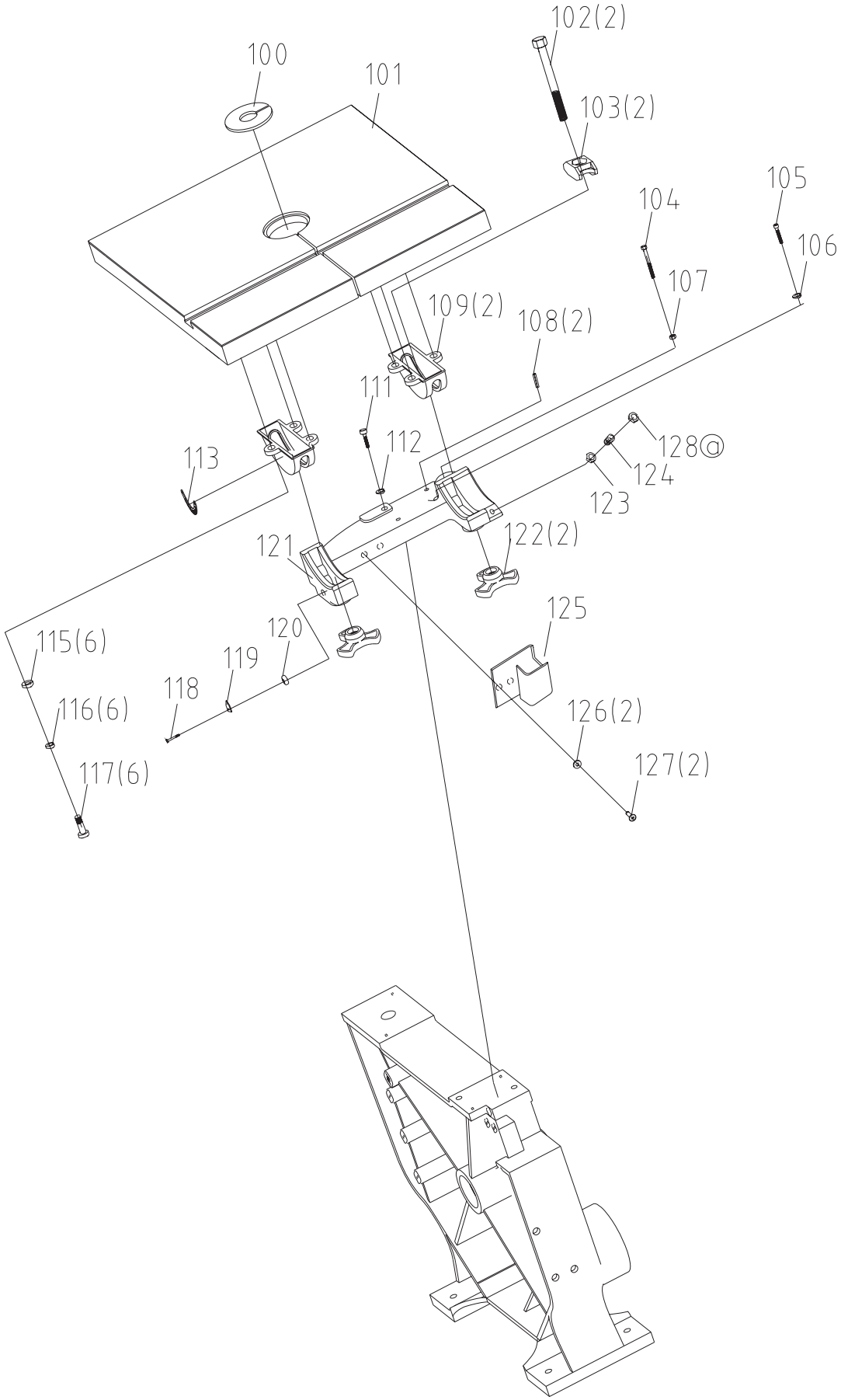
TROUBLESHOOTING GUIDE

This section covers the most common processing problems encountered in sawing and what to do about them. Do not make any adjustments until the bandsaw is unplugged and moving parts have come to a complete stop.

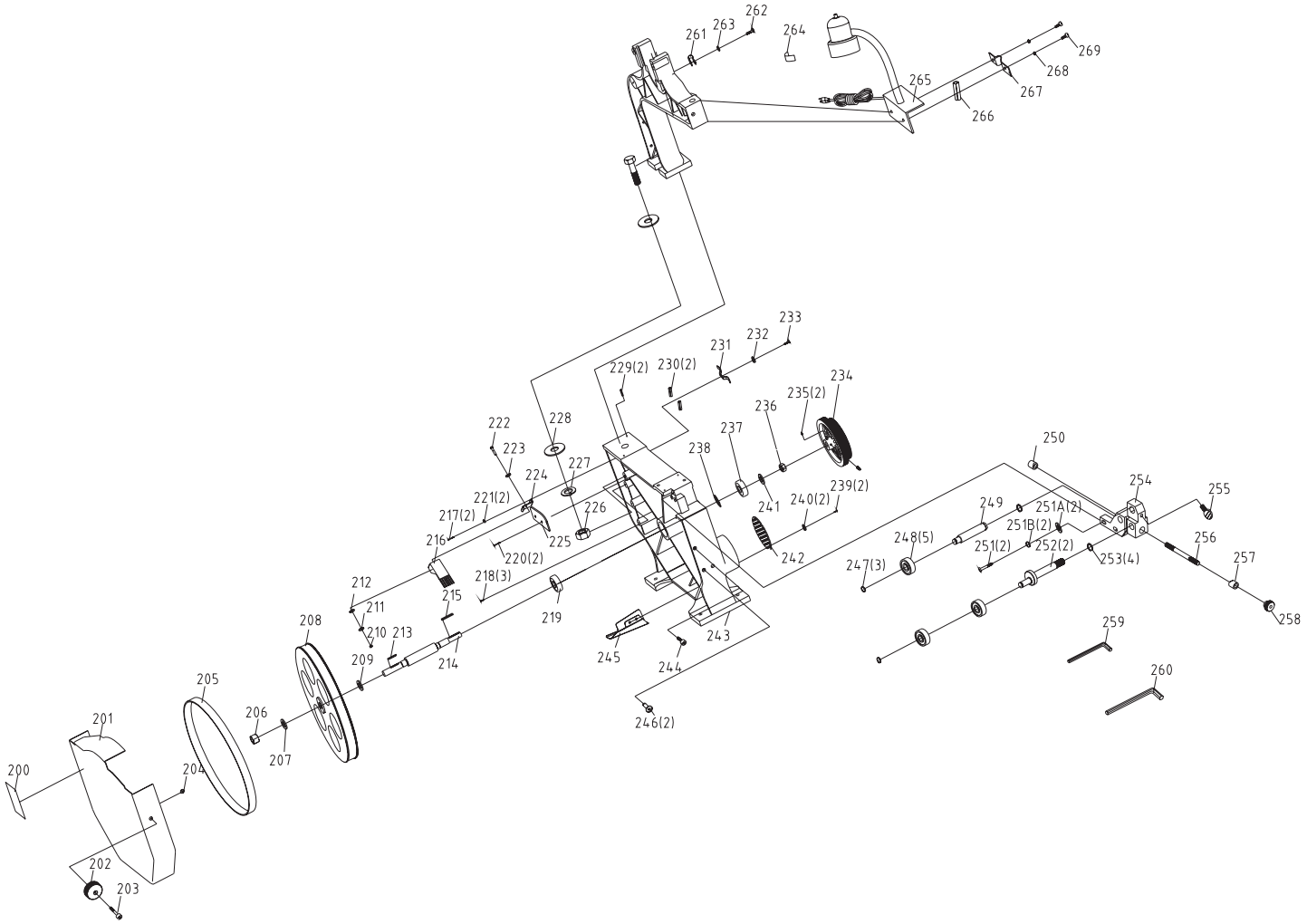
PROBLEM	LIKELY CAUSE(S)	SOLUTION
Saw stops or will not start.	1. Saw unplugged. 2. Fuse blown, or circuit breaker tripped. 3. Cord damaged.	1. Check plug connections. 2. Replace fuse, or reset circuit breaker. 3. Replace cord.
Does not make accurate 45° or 90° cuts.	1. Stop not adjusted correctly. 2. Angle pointer not set accurately. 3. Miter gauge out of adjustment.	1. Check blade with square and adjust stop. 2. Check blade with square and adjust pointer. 3. Adjust miter gauge.
Blade wanders during cut.	1. Warped wood. 2. Excessive feed rate. 3. Incorrect blade for cut. 4. Blade tension not set properly. 5. Guide bearings not set properly.	1. Select another piece of wood. 2. Reduce feed rate. 3. Change blade to correct type. 4. Set blade tension according to blade manufacturer’s specs. 5. Review guide bearing adjustment.
Saw makes unsatisfactory cuts.	1. Dull blade. 2. Blade mounted wrong. 3. Gum or pitch on blade. 4. Incorrect blade for cut. 5. Gum or pitch on table.	1. Replace blade. 2. Teeth should point down. 3. Remove blade and clean. 4. Change blade to correct type. 5. Clean table.
Blade does not come up to speed.	1. Extension cord too light or too long. 2. Low shop voltage.	1. Replace with adequate size and length cord. 2. Contact your local electric company.
Saw vibrates excessively.	1. Base on uneven floor. 2. Bad Poly V-belt. 3. Motor mount is loose. 4. Loose hardware.	1. Reposition on flat, level surface. 2. Replace v-belt. 3. Tighten motor mount hardware. 4. Tighten hardware.


1(4)
2
3
4
5
6
7
8
9
10
11(2)
12(3)
13(3)
14
15
16
17
18(2)
19
20
21
22
23
24
25
26
27(2)
28
29
30
31
32
33
33a
33b
34
35
36
37(2)
38
39
40
41
42
43
44
45(2)
46(2)
47
48(2)
49(2)
50
51(4)
52
53
54(2)
55
56
57
58(2)
59
60
61
62
63(2)
64(3)
65(2)
66
67(5)
68(3)
69(2)
69A(2)
70
71
72
73
74
75
76(4)
77(4)
81
82(2)
83(2)

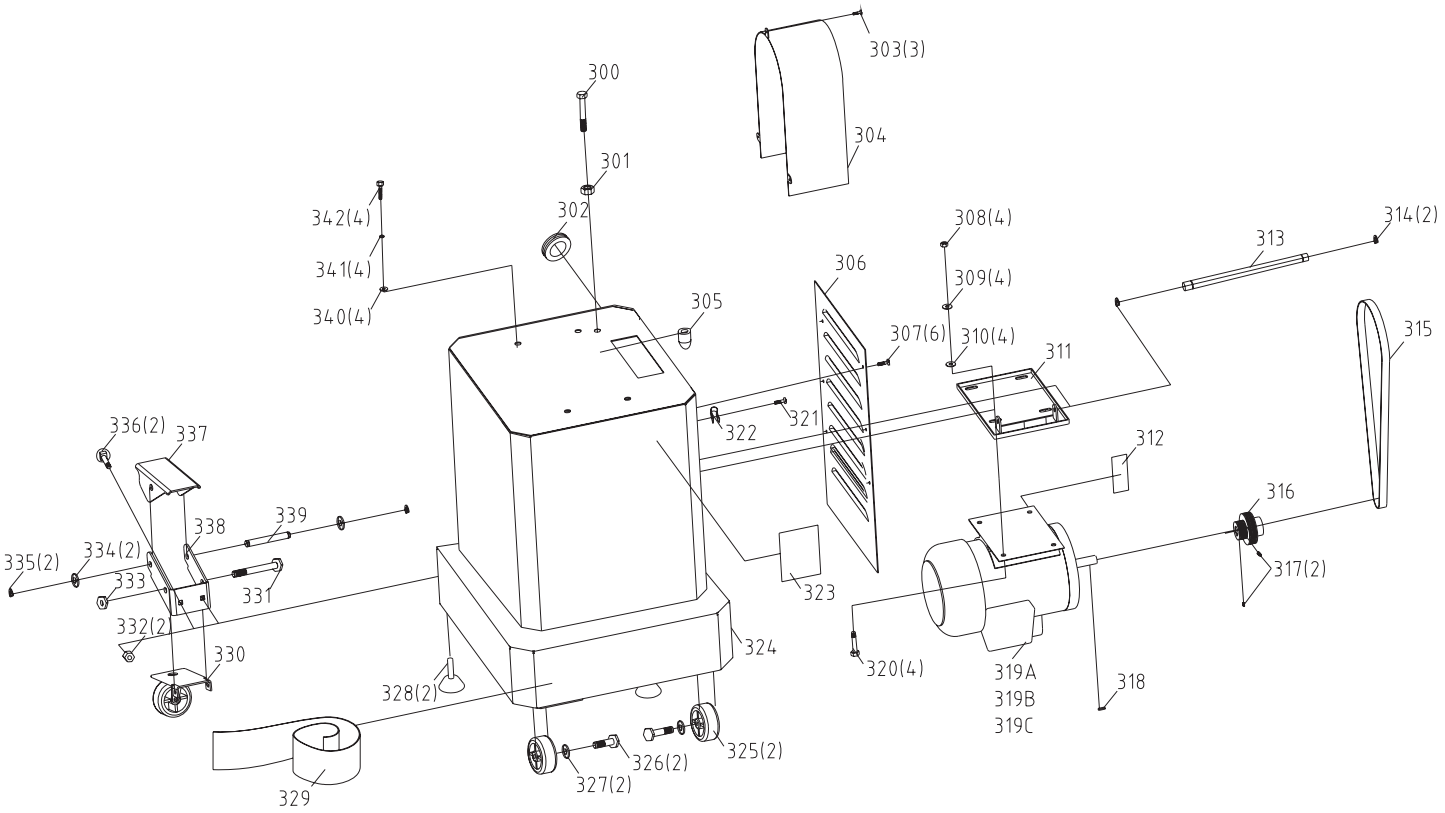
KEY NO.	PART NO.	DESCRIPTION	QTY.
1	OR93823	RIVET 2 X 8	4
2	OR73521	NAME PLATE	1
3	OR74400	UPPER DOOR	1
4	OR91754	NUT LOCK M6	1
5	OR74401	SAW BLADE (1/4"W 9105.5"L)	1
6	OR73526	TIRE	1
7	OR94825	NUT HEX M12	1
8	OR90304	WASHER FLATM12	1
9	OR73527	UPPER WHEEL	1
N/A	OR73525	UPPER WHEEL ASSEMBLY	
		(CONSISTS OF REF #'S 6,9)	
10	OR73554	STUD	1
11	OR94833	SCR HEX HD FLANGE	2
12	OR90235	NUT HEX FLANGE M6	3
13	OR93930	SCR PAN HD M6 X 10mm	3
14	OR73528	SPECIAL WASHER	1
15	OR73529	REAR UPPER GUARD	1
16	OR73530	WARNING LABEL	1
17	OR73531	SLEEVE	1
18	OR94826	BEARING 6202 2Z	2
19	OR73532	UPPER WHEEL SHAFT	1
20	OR73533	HINGE	1
21	OR73534	TENSION KNOB	1
22	OR73535	SLIDING BRACKET	1
23	OR94206	NUT WING M8	1
24	OR73536	ADJUST KNOB	1
25	OR73537	PIN	1
26	OR73538	SPRING	1
27	OR73539	FIBER WASHER	2
28	OR94828	NUT SQUARE M10	1
N/A	OR74250	HANDLE ASSEMBLY	
		(CONSISTS OF REF#'S 29, 30)	
29	OR73540	BALL KNOB	1
30	OR73541	HANDLE	1
31	OR94829	RETAINING RING EXTERNAL20	1
32	OR90232	PIN ROLLM4 X 20mm	1
33	OR73542	TENSION CRANK	1
33A	OR74402	SLEEVE	1
33B	OR74403	FENCE GLIDE PAD	1
34	OR73543	INSULATOR	1
35	OR73544	THUMB SCREW	1
36	OR91730	SCR SPECIAL PLASTIC SETM8 X 16mm	1
37	OR94830	RETAINING RING 8	2
38	OR73545	GEAR	1
39	OR73546	ADJUST KNOB	1
40	OR73547	GUIDE RACK	1
41	OR94843	WASHER FLATM20	1
42	OR94842	SCR HEX HD M20 X 70mm	1
43	OR73549	TENSION SHAFT	1
44	OR74404	UPPER FRAME	1
45	OR90311	WASHER FLATM8	2
46	OR94827	RETAINING RING INTERNAL35	2
47	OR94833	SCR HEX HD FLANGE M8 X 12mm	1
48	OR94777	SCR PAN HD M6 X 8mm	2
49	OR94793	WASHER EXT TOOTH M6	2
50	OR73552	SWITCH BRACKET	1
51	OR94831	SCR TAPM3.5 X 16mm	4
52	OR73550	SWITCH CORD	1
53	OR73551	POWER CORD	1
54	OR94832	STRAIN RELIEF (7P-2)	2
55	OR90283	SCR HEX SOC SETM8 X 8mm	1
56	OR73553	SWITCH ASSEMBLY	1
57	OR72415	BLADE GUARD	1
58	OR94834	SPECIAL WASHER	2
59	OR94835	SCR HEX HD LOCK M8 X 12mm	1
60	OR94836	SCR HEX HD FLANGE M8 X 50MM	1
61	OR73558	THUMB SCREW	1
62	OR73557	BEARING BRACKET UPPER	1
63	OR73556	THUMB SCREW	2
64	OR94837	RETAINING RING 10	3
65	OR73560	UPPER BEARING SHAFT	2
66	OR73889	SHAFT	1
67	OR94838	BEARING 628 2Z	5
68	OR94830	RETAINING RING 8	3
69	OR94777	SCR PAN HD M6 X 8mm	2
69A	OR90059	WASHER FLATM6	2
70	OR73562	WARNING LABEL	1
71	OR74252	BLADE GUARD	1
72	OR91812	SCR HEX SOC HD M6 X 22mm	1
73	OR73522	HAND WHEEL	1
74	OR74253	TRANSPARENT COVER	1
75	OR74254	TRANSPARENT COVER	1
76	OR90078	NUT HEX M4	4
77	OR90346	SCR PAN HD M4 X 8mm	4
81	OR74405	SAW GUARD PLATE I	1
82	OR90507	PAN SCREW M5 x 8mm	2
83	OR74406	SPRING WASHER M5	2


100
101
102(2)
103(2)
104
105
106
107
108(2)
109(2)
111
112
113
121
122(2)
123
124
125
126(2)
127(2)
128@
115(6)
116(6)
117(6)
118
119
120

KEY NO.	PART NO.	DESCRIPTION	QTY.
100	OR73563	TABLE INSERT	1
101	OR74256	GRANITE BANDSAW TABLE	1
102	OR94331	SCR HEX HD M10 X 50mm	2
103	OR73565	CLAMP SHOE	2
104	OR94222	SCR HEX HD M8 X 60mm	1
105	OR92174	SCR HEX SOC HD M8 X 30mm	1
106	OR90248	WASHER LOCK M8	1
107	OR90307	NUT HEX M8	1
108	OR73570	PIN	2
109	OR74257	TRUNNION	2
111	OR94840	SCR HEX SOC HD M8 X 35 mm	1
112	OR90248	WASHER LOCK M8	1
113	OR74258	SCALE	1
115	OR90059	WASHER FLAT M6	6
116	OR90502	WASHER LOCK M6	6
117	OR91758	SCR HEX SOC HD M6 X 16mm	6
118	OR90135	SCR PAN HD M4 X 6mm	1
119	OR73572	POINTER	1
120	OR90143	WASHER FLATM4	1
121	OR74259	TRUNNION SUPPORT	1
122	OR73573	KNOB	2
123	OR90235	NUT HEX M6	1
124	OR90508	SCR HEX HD M6 X 20mm	1
125	OR74260	LOWER BLADE GUARD	1
126	OR90145	WASHER LOCK M5	2
127	OR90507	SCR PAN HD M5 X 8mm	2
128	OR93370	LOCK NUT M6	1


200
201
202
203
204
205
206
207
208
209
210
211
212
213
214
215
216
217(2)
218(3)
219
220(2)
221(2)
222
223
224
225
226
227
228
229(2)
230(2)
231
232
233
234
235(2)
236
237
238
239(2)
240(2)
241
242
243
244
245
246(2)
247(3)
248(5)
249
250
251(2)
251A(2)
251B(2)
252(2)
253(4)
254
255
256
257
258
259
260
261
262
263
264
265
266
267
268
269

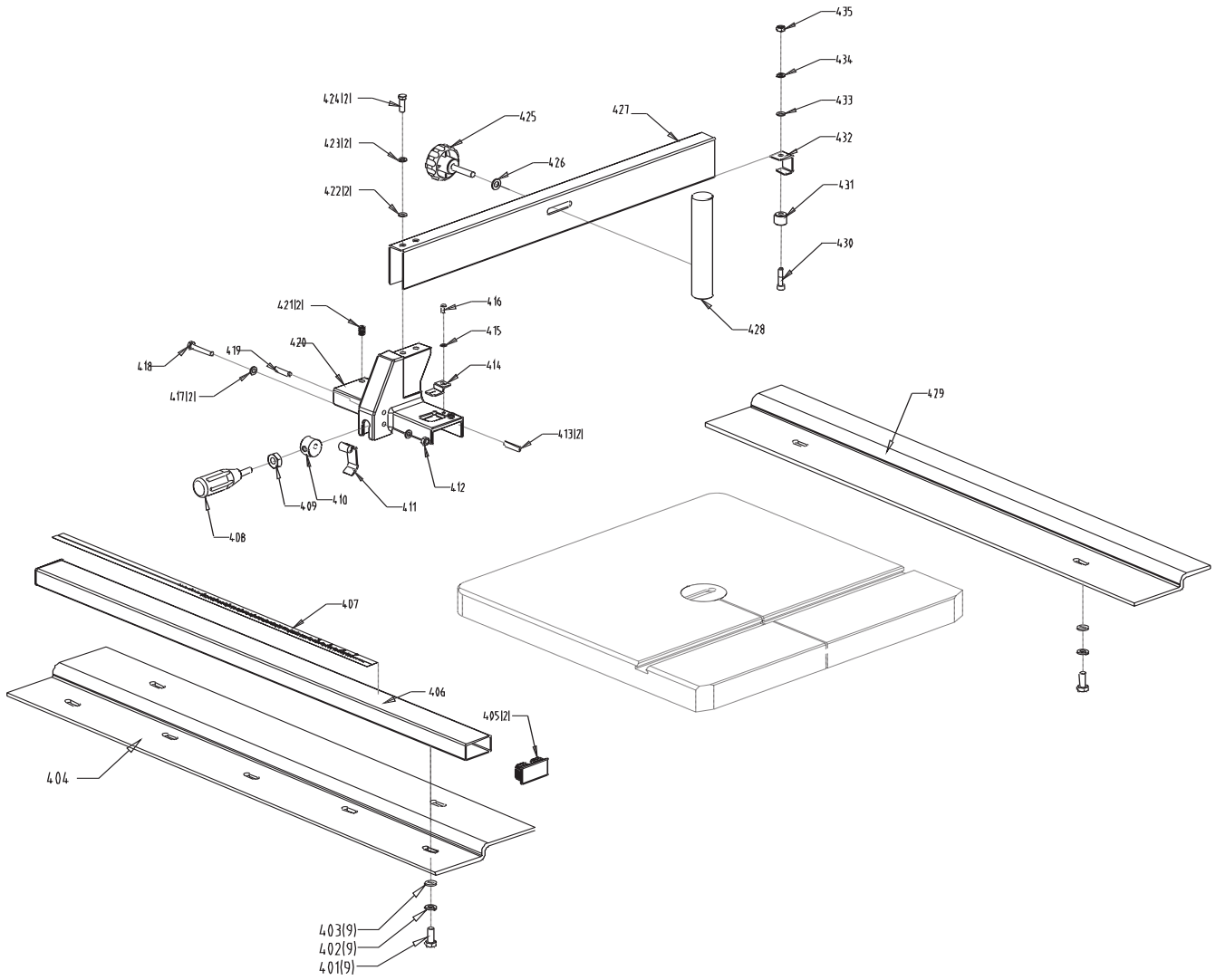
KEY NO.	PART NO.	DESCRIPTION	QTY.
200	OR73578	WARNING LABEL	1
201	OR73579	LOWER GUARD ASSEMBLY	1
202	OR73522	HAND WHEEL	1
203	OR91812	SCR HEX SOC HD M6 X 22mm	1
204	OR91754	NUT LOCK M6	1
205	OR73526	TIRE	1
206	OR94846	NUT HEX M20	1
207	OR94847	WASHER FLATM20	1
N/A	OR73580	LOWER WHEEL ASSEMBLY(CONSISTS OF REF#'S 205, 208)	N/A
208	OR73581	LOWER WHEEL	1
209	OR73583	SPECIAL WASHER	1
210	OR90381	NUT HEX M5	1
211	OR90145	WASHER LOCK M5	1
212	OR90462	WASHER FLATM5	1
213	OR94848	KEY5 X 9 X 22	1
214	OR73584	LOWER DRIVE SHAFT	1
215	OR94849	KEYC5 X 40	1
216	OR73576	BRUSH	1
217	OR94841	SCR PAN HD M5 X 6mm	2
218	OR93930	SCR PAN HD M6 X 10mm	3
219	OR94851	BEARING 6204 2Z	1
220	OR94777	SCR PAN HD M6 X 8mm	2
221	OR90145	WASHER LOCK M5	2
222	OR90505	SCR PAN HD M5 X 12mm	1
223	OR90145	WASHER LOCK M5	1
224	OR73575	BRUSH BRACKET	1
225	OR73586	BACK GUARD	1
226	OR94845	NUT HEX M20	1
227	OR94844	WASHER LOCK M20	1
228	OR94843	WASHER FLATM20	1
229	OR73587	PIN	2
230	OR73588	WIRE JACKET	2
231	OR73589	WIRE CLAMP	1
232	OR90145	WASHER LOCK M5	1
233	OR90507	SCR PAN HD M5 X 8mm	1
234	OR73585	PULLEY	1
235	OR90222	SCR HEX SOC SSETM6 X 10mm	2
236	OR94852	NUT HEX M20 X 1	1
237	OR94851	BEARING 6204 2Z	1
238	OR94850	WAVE WASHER	1
239	OR90507	SCR PAN HD M5 X 8mm	2
240	OR90145	WASHER LOCK M5	2
241	OR73583	SPECIAL WASHER	1
242	OR73590	GUARD	1
N/A	OR74261	BASE ASSEMBLY(CONSISTS OF REF#'S 219,236,237,238,241,243)	
243	OR74262	BASE	1
244	OR94853	SCR HEX SOC HD M5 X 6mm	1
245	OR73592	DUST PLATE	1
246	OR90501	SCR PAN HD M6 X 16mm	2
247	OR94830	RETAINING RING 8	3
248	OR94838	BEARING 628 2Z	5
249	OR73594	LOWER BRACKET	1
250	OR73593	SLEEVE	1
251	OR95205	SCR PAN HD M5 X 30mm	2
251A	OR90462	M5 FLAT WASHER	2
251B	OR90145	M5 SPRING WASHER	2
252	OR73595	LOWER BEARING SHAFT	2
253	OR94837	RETAINING RING 10	4
254	OR73596	LOWER BEARING BRACKET	1
255	OR73597	THUMB SCREW	1
256	OR73598	SPECIAL SCREW	1
257	OR73599	SLEEVE	1
258	OR73600	SPECIAL KNOB	1
259	OR90290	WRENCH HEX 3mm	1
260	OR90291	WRENCH HEX 4mm	1
261	OR74255	WIRE CLIP	1
262	OR90507	SCR PAN HD M5 X 8mm	1
263	OR74408	M4 BIG WASHER	1
264	OR74267	WARNING LABEL	1
265	OR74264	WORK LIGHT ASSEMBLY	1
266	OR74265	INSULATOR	1
267	OR74266	BRACKET	1
268	OR90145	WASHER LOCK M5	2
269	OR90877	SCR HEX SOC HD M5 X 12mm	2



KEY NO.	PART NO.	DESCRIPTION	QTY.
300	OR94856	SCR HEX HD M10 X 100mm	1
301	OR90228	NUT HEX M10	1
302	OR73543	CABLE GROMMET	1
303	OR94618	SCR PAN HD FLANGE M6 X 10mm	3
304	OR73608	UPPER BELT GUARD	1
305	OR73606	DAMPING WASHER	1
306	OR73609	ACCESS PANEL	1
307	OR94857	SCR PAN HD M6 X 15mm	6
308	OR90307	NUT HEX M8	4
309	OR90248	WASHER LOCK M8	4
310	OR90311	WASHER FLATM8	4
311	OR73611	MOTOR BRACKET	1
312	OR70380	MOTOR LABEL	1
313	OR73612	PIN	1
314	OR94858	RETAINING RING E-RING 9	2
315	OR73613	BELT6PJ1050	1
316	OR73614	MOTOR PULLEY	1
317	OR90222	SCR HEX SOC SETM6 X 10mm	2
318	OR94859	KEYC5 X 45	1
319A	OR70433	MOTOR	1
319B	OR73615	START CAPACITOR	-
319C	OR73616	RUN CAPACITOR	-
320	OR94775	SCR CARRIAGE HD M8 X 20mm	4

KEY NO.	PART NO.	DESCRIPTION	QTY.
321	OR92137	SCR PAN HD M5 X 12mm	1
322	OR73610	CABLE TIE	1
323	OR74263	SPEC LABEL	1
324	OR73617	CABINET	1
325	OR73618	CASTER WHEEL	2
326	OR91497	SCR HEX HD M8 X 50mm	2
327	OR90311	WASHER FLATM8	2
328	OR73620	FOOT	2
329	OR73619	TAPE	1
330	OR73601	CASTER ASSEMBLY	1
331	OR91502	SCR HEX HD 5/16-18 X 4”	1
332	OR94771	NUT HEX FLANGE M8	2
333	OR94774	NUT LOCK 5/18-18	1
334	OR94854	WASHER FLAT1/2”	2
335	OR94855	RETAINING RING EXTERNAL1/2”	2
336	OR94775	SCR CARRIAGE HD M8 X 20mm	2
337	OR73604	FOOT PEDAL	1
338	OR73603	REAR WHEEL BRACKET	1
339	OR73602	PIN	1
340	OR90311	WASHER FLATM8	4
341	OR90248	8WASHER LOCK M8	4
342	OR93891	SCR HEX HD M8 X 40mm	4
N/A	OR73672	50100 USER MANUAL ENGLISH	-

◆ NOTES ◆



KEY NO.	PART NO.	DESCRIPTION	QTY.
401	OR91749	SCR HEX HD M6 X 25mm	9
402	OR90502	WASHER LOCK M6	9
403	OR90529	WASHER FLAT M6	9
404	OR74268	FRONT RAIL	1
405	OR72519	END CAP	2
406	OR72523	GUIDE TUBE	1
407	OR72525	SCALE	1
408	OR72500	FENCE HANDLE	1
409	OR90307	NUT HEX M8	1
410	OR72499	CAM	1
411	OR72498	CLAMP	1
412	OR95206	NUT HEX FLANGE M6	1
413	OR72497	SLIDE BLOCK	2
414	OR72496	POINTER	1
415	OR90431	WASHER FLAT M4	1
416	OR91774	SCR PAN HD M4 X 10mm	1
417	OR90529	WASHER FLAT M6	2
418	OR92723	SCR HEX HD M6 X 40mm	1

KEY NO.	PART NO.	DESCRIPTION	QTY.
419	OR93376	PIN SPRING M6 X 30mm	1
420	OR72501	FENCE BODY	1
421	OR94235	SCR HEX SOC SET M8 X 12mm	2
422	OR90311	WASHER FLAT M8	2
423	OR90248	WASHER LOCK M8	2
424	OR92735	SCR HEX HD M8 X 25mm	2
425	OR72490	LOCK KNOB	1
426	OR90311	WASHER FLAT M8	1
427	OR72492	FENCE	1
428	OR72495	RESAW POST	1
429	OR74269	REAR RAIL	1
430	OR93936	SCR HEX SOC SET M6 X 25mm	1
431	OR72494	PAD	1
432	OR72493	REAR HOOK	1
433	OR90529	WASHER FLAT M6	1
434	OR90502	WASHER LOCK M6	1
435	OR90235	NUT HEX M6	1

STEEL CITY TOOL WORKS

www.steelcitytoolworks.com

1-877-SC4-TOOL

(1-877-724-8665)

5 Year Warranty